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<p>(21) International Application Number: <b>PCT/US97/08466</b></p> <p>(22) International Filing Date: <b>16 May 1997 (16.05.97)</b></p> <p>(30) Priority Data: 8-148392 17 May 1996 (17.05.96) JP</p> <p>(71) Applicant (for all designated States except US): THE DOW CHEMICAL COMPANY [US/US]; 2030 Dow Center, Midland, MI 48674 (US).</p> <p>(72) Inventors; and</p> <p>(75) Inventors/Applicants (for US only): JACOBSEN, Grant, B. [GB/US]; 5454 Newcastle Drive #1845, Houston, TX 77081 (US). VAN DUN, Jozef, J. [BE/BE]; Pater Damielaan 76, B-2240 Zandhoven (BE). CHUM, Pak-Wing, S. [US/US]; 126 Juniper Street, Lake Jackson, TX 77566 (US). MEISKE, Larry, A. [US/US]; 103 Paintbrush, Lake Jackson, TX 77566 (US). MATSUSHITA, Fumio [JP/JP]; 880-14, Horinan, Kurashiki-shi, Okayama-ken 710 (JP). MIYAMOTO, Akira [JP/JP]; 1005-1, Higashitomii, Kurashiki-shi, Okayama-ken 710 (JP).</p> <p>(74) Agent: CARTER, James, G.; Patent Dept., B-1211, 2301 Brazosport Boulevard, Freeport, TX 77541 (US).</p>		<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</p> <p><b>Published</b> With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</p>	
<p>(54) Title: PROCESS FOR PREPARING COPOLYMERS AND BLEND COMPOSITIONS CONTAINING THE SAME</p> <p>(57) Abstract</p> <p>Disclosed is a process for the preparation of an ethylene copolymer by copolymerizing ethylene and at least one comonomer selected from a compound represented by the formula <math>H_2C-CHR</math> wherein R is an alkyl group or an aryl group, and a diene, in the presence of a solid catalyst system comprising a support, a transition metal compound and an activator capable of converting the transition metal compound into a catalytically active transition metal complex.</p>			

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## PROCESS FOR PREPARING COPOLYMERS AND BLEND COMPOSITIONS CONTAINING THE SAME

This application claims priority from Japanese Application H08-148392 filed on May 17, 1996 (Attorney's Docket No. C-42862).

5 The present invention relates to a novel ethylene copolymer and a method for producing the same. More particularly, the present invention is concerned with a novel ethylene copolymer comprising a copolymer of ethylene with at least one comonomer selected from the group comprising compounds represented by the formula  $H_2C = CHR$  wherein R represents a  $C_1 - C_{20}$  linear, 10 branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or cyclic diene, and having a specific density, and having not only a specific molecular weight distribution characteristic but also a specific comonomer content distribution characteristic.

The present invention also relates to blend compositions comprising said 15 novel ethylene copolymer and:

- a) a second ethylene copolymer of the present invention of different molecular weight or density; or
- b) a homogeneous narrow composition distribution ethylene interpolymer;
- c) a heterogeneous broad composition distribution ethylene interpolymer or
- d) a homopolymer (prepared by a catalyst component other than that used to prepare the ethylene copolymer of the present invention ); or
- e) a combination of any two or more of a), b) c) or d).

25 The present invention is also concerned with a novel method for producing the blend compositions comprising the ethylene copolymer of the present invention.

The ethylene copolymer of the present invention has great advantages

which have not been provided by conventional ethylene copolymers. that is , it contains no impurities such as a wax, a gel . In addition both the ethylene copolymer and blend compositions therefrom of the present invention also have excellent properties, such as high impact strength and excellent environmental 5 stress cracking resistance. such that they can be advantageously used for the production of laminate films, blow-molded articles, pipes. coating materials for electric transmission cables, .

Ethylene copolymers are widely used in various application fields, such as the production of films, blow-molded products, pipes and coating materials 10 for electric transmission cables. With respect to any of these applications. it is required that an ethylene copolymer not only contain few impurities. such as wax, gels , but also exhibit excellent properties. such as high impact strength and high environmental stress cracking resistance (hereinafter. frequently referred to as "ESCR properties"). However attempts to vary the molecular 15 structure of a polymer to cause an improvement in one such property often results in a loss of performance in another. For instance polymers exhibiting high stiffness and heat resistance should have high crystallinity and low comonomer content. however this can cause a loss of toughness. ESCR. low optical properties and poor heat seal performance. Similarly for improved 20 polymer processability (low extrusion amp and back pressure and no melt fracture) it is desirable to use polymers having a low molecular weight, and a broad molecular weight distribution with significant levels of long chain branching. However broad molecular weight distribution, especially at low 25 polymer molecular weight, often causes wax buildup on the die, smoke generation on the extruder, and taste and odor problems in the resulting fabricated articles.

It is known that improvement in impact and environmental stress crack

resistance of an ethylene copolymer, can be achieved by decreasing the comonomer content of the low molecular weight fraction of the ethylene copolymer to a level as low as possible while increasing the comonomer content of the high molecular weight fraction of the ethylene copolymer to a 5 level as high as possible. It has also been demonstrated (as for example by Zhou et al, Polymer, Vol. 24, p. 2520 (1993)) that large strain properties such as toughness, tear, impact and ESCR can also be improved by the presence of "tie molecules" in the resin. High molecular weight molecules with the highest comonomer content (that is the highest degree of short chain branching) are 10 responsible for the formation of most of the tie molecules upon crystallization.

Thus it would be highly desirable for a copolymer to have a specific comonomer content distribution characteristic, wherein, in one aspect, the lower the molecular weight of a copolymer fraction in a molecular weight distribution of a said copolymer, the lower the comonomer content of the 15 copolymer fraction; and, in the other aspect, the higher the molecular weight of a fraction of said copolymer, the higher the comonomer content of the copolymer fraction.

However, in ethylene copolymers which are produced using a conventional Ziegler-Natta catalyst, it is likely that the lower the molecular 20 weight of a copolymer fraction, the higher its comonomer content. Thus, such conventional ethylene copolymers have a comonomer content distribution which is completely contrary to the above-mentioned desired comonomer content distribution. Therefore, such conventional ethylene copolymers are at a disadvantage with respect to desirable properties, such as improved impact 25 strength and ESCR.

Attempts to maximize toughness, modulus, impact strength and ESCR of ethylene copolymers has resulted in the preparation and use of blend

compositions made out of two or more ethylene copolymer components of differing molecular structures. In addition to separately blending selected individual polymer components after their manufacture and isolation (so called "off-line" blending), such compositions can also be prepared by a method in 5 which a copolymerization of ethylene with a comonomer is conducted by a multi-stage polymerization, using a plurality of different polymerization reactors, capable of providing different copolymerization conditions. This allows so called "in reactor" or "in process" production of ethylene copolymers comprising a mixture of a low molecular weight copolymer component, having 10 a low comonomer content, and a high molecular weight copolymer component having a high comonomer content.

Such blend compositions containing solely Ziegler catalyst products are described in a number of patents. For example, Nelson (US 3,280,220, Phillips Petroleum) teaches that a blend of an ethylene homopolymer of low molecular 15 weight (formed in a solution process) and an ethylene/butene-1 copolymer of high molecular weight (formed in a particle forming process) provides higher ESCR and is more advantageous for containers and pipe than other such blends.

Hoblitt et al. (US 3,660,530, the Dow Chemical Company) teaches a method where part of a homopolymer produced after a first reaction step is 20 subjected to 1-butene. The still active catalyst then produces a block copolymer of polyethylene and polymerized butene-1. Both components are then admixed. The resultant blend has improved ESCR properties.

Fukushima et al. (US 4,438,238) disclose blends consisting of components with densities between .910 and .940 g/cm<sup>3</sup> and broad molecular 25 weight distributions with the polymers having substantially no long chain branches. These blends were found to have processability similar to that of high pressure polyethylene

Bailey et al. (US 4,547,551) teach that ethylene polymer blends of a high molecular weight ethylene polymer, preferably an ethylene/α-olefin copolymer, and a low molecular weight ethylene polymer, preferably an ethylene homopolymer, both preferentially having a narrow molecular weight distribution and low levels of long chain branching, exhibit excellent film properties and a better balance of stiffness and impact and ESCR, than expected for polyethylene of comparable density and flow.

5 Morimoto et al. (US 5,189,106, and 5,260,384) disclose blends consisting of a high molecular weight copolymer in combination with a low 10 molecular weight homopolymer having good processability and excellent low temperature mechanical properties.

Boehm et al., (Advanced Materials 4 (1992) no 3, p 237), disclose the cascade polymerization process in which the comonomer is introduced in the high molecular weight fraction of the polymer resulting in a larger amount of 15 comonomer being present at the same overall density. This in turn results in a polymer composition having improved rigidity-lifetime (failure time) compared to conventional unimodal copolymers. Several patents have also appeared teaching the process to produce such materials in such cascade processes including EP 0 022 376 (Morita et al.).

20 Unexamined Japanese Patent Application Laid-Open Specification Nos. 61-221245 and 61-57638, disclose attempts to increase the comonomer content of high molecular weight copolymer fractions by a method in which a low molecular weight polymer having a low comonomer content and a high molecular weight polymer having a high comonomer content are separately 25 produced and blended by means of a kneader, or a method in which a copolymerization of ethylene with a comonomer is conducted by multi-stage polymerization, thereby producing an ethylene copolymer comprising a mixture

of a low molecular weight polymer component having a low comonomer content and a high molecular weight polymer component having a high comonomer content.

Finally, Sakurai et al (U.S.4,230,831) disclose that it is beneficial to mix 5 low density polyethylene with various blend compositions to improve polymer die swell or melt tension.

In single component ethylene copolymers produced by employing a Ziegler catalyst, some improvement is achieved with respect to impact 10 resistance and ESCR properties. Such ethylene copolymers, however, inherently exhibit not only a broad molecular weight distribution but also a broad tail on both the low and high molecular weight side of the molecular weight distribution. The presence of the low molecular weight material can disadvantageously lead to wax formation. On the other hand, the high molecular weight material can disadvantageously lead to gel formation .

15 In addition, blend compositions which are a mixture of such ethylene copolymers produced by a Ziegler catalyst, may comprise component copolymers which are completely different from each other in properties, that is , a low molecular weight polymer component having a low comonomer content and a high molecular weight polymer component having a high 20 comonomer content. This can lead to the component polymers undergoing phase separation such that the dispersion of the component polymers becomes non-uniform, and thus not only does the ethylene copolymer become non-uniform in properties but also gel formation occurs.

As an alternative to the use of Ziegler-Natta catalysts, the use of 25 metallocene catalysts has recently been proposed (DE 31271332 ) and commercialized. As disclosed in, for example, Worldwide Metallocene Conference (Metcon) '93 May 26-28, Houston Texas, p. 171-172 and p. 235-

244 (1993) and Proceedings of 5th International Business Forum on Specialty Polyolefins '95, September 20-22, Houston Texas, p. 341-352 (1995), an ethylene copolymer produced using such a metallocene catalyst has characteristics such that both a low molecular weight fraction and a high 5 molecular weight fraction have approximately the same comonomer content, and that the comonomer content distribution is almost uniform across the molecular weight distribution of the copolymer. That is, an ethylene copolymer produced using a metallocene catalyst has a more uniform comonomer content distribution than that of an ethylene copolymer produced using a Ziegler-Natta 10 catalyst. On the other hand, however, ethylene copolymers produced using a metallocene catalyst are still unsatisfactory with respect to desired improvements in impact resistance and ESCR properties of products of such copolymers.

Again, as was the case with Ziegler catalyst products, attempts to 15 improve properties such as ESCR and impact resistance of products of metallocene catalysts have included their incorporation into blend compositions. A number of techniques have been proposed to prepare such blends, including a method in which two or more different ethylene copolymers having different comonomer contents are separately produced and blended by 20 means of a kneader or a method in which an ethylene copolymer comprised of a mixture of two or more different ethylene copolymer components having different comonomer contents is produced by multi-stage polymerization (see, for example, EP 0 447 035). Further, it has also been proposed to use a method in which a mixture of two or more different types of metallocene catalysts is 25 used to produce an ethylene copolymer comprised of a mixture of two or more different ethylene copolymer components having different comonomer contents (see, for example, U.S. Patent Nos. 4,937,299 and 4,530,914).

However, an ethylene copolymer produced using a metallocene catalyst typically has a very narrow molecular weight distribution ( $M_w/M_n$ ) of approximately 2. Therefore, when two different types of copolymers, namely a low molecular weight copolymer and a high molecular weight copolymer which are extremely different in molecular weight from each other, are produced using different metallocene catalysts, the respective amounts of copolymer chains having common molecular weights is very small in the two different copolymers, so that the compatibility between these two different copolymers is very poor.

In order to solve the above-mentioned problem, a method in which an ethylene copolymer produced using a metallocene catalyst is blended with an ethylene copolymer produced using a Ziegler-Natta catalyst has been proposed, for example, in EP 0 439 964 and EP 0 435 514. Further, a method in which an ethylene copolymer produced using a metallocene catalyst is blended with an ethylene copolymer produced by a high pressure polymerization process has been disclosed, for example, in Unexamined Japanese Patent Application Laid-Open Specification Nos. 6-207059 and 6-329848.

However there remains a requirement to produce an ethylene copolymer which not only contains few impurities such as wax, gels, but also has excellent properties, including high impact strength and excellent ESCR. There also remains a requirement to develop an ethylene copolymer which contains no impurities such as a wax, a gel while simultaneously exhibiting the above-mentioned desired comonomer content distribution, namely, in one aspect, the lower the molecular weight of a copolymer fraction, the lower the comonomer content of the copolymer fraction; and, in the other aspect, the higher the molecular weight of a copolymer fraction, the higher the comonomer content of the copolymer fraction.

There also remains a requirement to produce blend compositions comprising said ethylene copolymers which also have excellent properties, such as high impact strength and excellent ESCR properties. Finally there also remains a requirement for producing blend compositions with good 5 compatibility between the two components and exhibiting improved uniformity and balance in properties while having low wax content and low tendency for gel formation.

It has surprisingly been found that such a required ethylene copolymer 10 and blend composition can be produced using the polymers and the specific polymerization and blending processes of the present invention.

Accordingly, it is one object of the present invention to provide a novel ethylene copolymer which not only contains substantially no impurities such as a wax, a gel, but also exhibits a comonomer content distribution in which the 15 lower the molecular weight of a fraction of said copolymer the lower the comonomer content and the higher the molecular weight of a fraction of said copolymer the higher the comonomer content.

It is also an object of the present invention to provide novel blend compositions comprising said ethylene copolymer which exhibit an excellent 20 balance and uniformity of properties such as high impact strength and excellent ESCR while also having a low wax content and a reduced tendency to gel formation.

The foregoing and other objects, features and advantages of the present invention will become apparent to those skilled in the art from the following 25 detailed description and appended claims.

All references herein to elements or metals belonging to a certain Group refer to the Periodic Table of the Elements published and copyrighted by CRC

Press, Inc., 1989. Also any reference to the Group or Groups shall be to the Group or Groups as reflected in this Periodic Table of the Elements using the IUPAC system for numbering groups.

Any numerical values recited herein include all values from the lower 5 value to the upper value in increments of one unit provided that there is a separation of at least 2 units between any lower value and any higher value. As an example, if it is stated that the amount of a component or a value of a process variable such as, for example, temperature, pressure, time is, for example, from 1 to 90, preferably from 20 to 80, more preferably from 30 to 70, 10 it is intended that values such as 15 to 85, 22 to 68, 43 to 51, 30 to 32 etc. are expressly enumerated in this specification. For values which are less than one, one unit is considered to be 0.0001, 0.001, 0.01 or 0.1 as appropriate. These 15 are only examples of what is specifically intended and all possible combinations of numerical values between the lowest value and the highest value enumerated are to be considered to be expressly stated in this application in a similar manner.

The term "hydrocarbyl" as employed herein means any aliphatic, cycloaliphatic, aromatic, aryl substituted aliphatic, aryl substituted cycloaliphatic, aliphatic substituted aromatic, or aliphatic substituted 20 cycloaliphatic groups and any combination thereof.

The term "hydrocarbyloxy" means a hydrocarbyl group having an oxygen linkage between it and the carbon atom to which it is attached.

The term "silyl" means a group having a silicon linkage between it and the carbon atom to which it is attached.

25 The term "germyl" means a group having a germanium linkage between it and the carbon atom to which it is attached.

The term "substituted cyclopentadienyl" is intended to include ring-

substituted or polynuclear derivatives of the cyclopentadienyl moiety wherein the substituent is hydrocarbyl, hydrocarbyloxy, hydrocarbyl amino, cyano, halo, silyl, germyl, siloxy or mixtures thereof or two such substituents are a hydrocarbylene group, the substituent (or two substituents together) having up to 30 non-hydrogen atoms. Specific examples of substituted cyclopentadienyls include indenyl, tetrahydroindenyl, fluorenyl, and octahydrofluorenyl groups.

5 The term "Bronsted Acid cation" means a cation which acts as a proton donor.

10 The term "interpolymer" is used herein to indicate a polymer wherein at least two different monomers are polymerized to make the interpolymer. This includes copolymers, terpolymers, etc.

The density of the polymer compositions for use in the present invention was measured in accordance with ASTM D-792.

15 The molecular weight of the polymer compositions for use in the present invention is conveniently indicated using a melt index measurement according to ASTM D-1238, Condition 190°C/2.16 kg (formally known as "Condition (E)" and also known as  $I_2$ ) was determined, as were conditions 190°C/5 kg, 10 kg and 21.6 kg known as  $I_5$ ,  $I_{10}$ , and  $I_{21}$  respectively. Melt index is inversely proportional to the molecular weight of the polymer. Thus, the higher the 20 molecular weight, the lower the melt index, although the relationship is not linear. Melt flow ratios were taken from any pair of these values.

Other useful physical property determinations made on the novel polymer compositions described herein include the melt flow ratio (MFR): measured by determining " $I_{10}$ " (according to ASTM D-1238, Condition 25 190°C/10 kg (formerly known as "Condition (N)") and dividing the obtained  $I_{10}$  by the  $I_2$ . The ratio of these two melt index terms is the melt flow ratio and is designated as  $I_{10}/I_2$ . Other melt flow ratios measured include  $I_{21.6}/I_5$ , and  $I_{21.6}/I_2$ .

The molecular weight ( $M_w$ ) and distribution ( $M_w/M_n$ ) of the polymers of the present invention were determined by gel permeation chromatography (GPC) on a Waters 150C high temperature chromatographic unit equipped with mixed porosity columns, operating at a system temperature of 140°C. The 5 solvent was 1,2,4-trichlorobenzene, from which 0.3 percent by weight solutions of the samples were prepared for injection. The flow rate was 1.0 milliliters/minute and the injection size was 100 microliters.

The molecular weight determination was deduced by using narrow 10 molecular weight distribution polystyrene standards (from Polymer Laboratories) in conjunction with their elution volumes. The equivalent polyethylene molecular weights were determined by using appropriate Mark-Houwink coefficients for polyethylene and polystyrene (as described by Williams and Ward in Journal of Polymer Science. Polymer Letters, Vol. 6, (621) 1968) to derive the following equation:

15  $M_{\text{polyethylene}} = a * (M_{\text{polystyrene}})^b.$

In this equation,  $a = 0.4316$  and  $b = 1.0$ . Weight average molecular weight,  $M_w$ , and number average molecular weight,  $M_n$ , was calculated in the usual manner according to the following formula:

$$M_j = (\sum w_i (M_i^j))^j;$$

20 where  $w_i$  is the weight fraction of the molecules with molecular weight  $M_i$  eluting from the GPC column in fraction  $i$  and  $j = 1$  when calculating  $M_w$  and  $j = -1$  when calculating  $M_n$ .

The tensile properties of the molded materials were measured in accordance with ASTM D 638-76. Tensile strength, yield, toughness and 2% 25 secant modulus of the films was measured in accordance with ASTM D-882; PPT tear was measured in accordance with ASTM D-2582.

The modulus of elasticity of the materials was measured in accordance

with ISO 527.

The viscosity number of the materials in decaline was measured in accordance with ISO 1191.

Haze was measured on a 0.5 mm thick compression molded specimen 5 according to ASTM D 1003.

The Double-V notched impact strength of the materials was measured in accordance with DIN 53753 (1J pendulum).

The impact properties were evaluated in accordance with JIS-K7111.

The critical strain energy release rate  $G_C$  was measured in the Charpy 10 mode, in accordance with the procedure described by E. Plati and J.G. Williams in Polymer Engineering and Science, June, 1975, Volume 15, No 6, pp. 470 to 477. For each temperature at least 6 samples are used. The sample dimensions are 125 mm x 10 mm x 10 mm. The bars are machined out of thick 15 compression molded sheets. The procedure used to mold these sheets was a modification of the procedure outlined in "A compression molding technique for thick sheets of thermoplastics" by M. J. Cawood and G. A. H. Smith in Polymer Testing 1 (1980), 3-7, was used:

Thus the polymer granules or powders were compression molded in a 10 20 mm thick mold, laterally insulated using Teflon™. They were heated up to 160°C and kept at 6.7 MPa for three minutes followed by three one minute cycles of exertion and release. Excessive flash was removed. The material was then heated to 180°C and kept for about 5 minutes at 6.7 MPa, which was also exerted and released for 3 cycles of one minute each. Finally the melt was 25 solidified under a pressure of 1.7 MPa and slowly cooled overnight by switching of the heating.

The Bending ESCR Test was carried out in 10wt% of surface-active agent solution in accordance with JIS-K6760. The testing temperature was

50°C or 80°C.

The Pennsylvania Notch Test is a slow crack growth test, performed following the procedure described by X. Lu and N. Brown, Polymer Testing 11 5 (1992), pages 309319. The test is conducted at 2.4 MPa and 80°C. The sample dimensions are 50 mm x 25 mm x 10 mm and are machined from the same sheet as the  $G_c$  bars.

Viscosities were measured on an Rheometrics mechanical spectrometer at 190°C in the oscillatory mode.

10 Comonomer content was measured using infrared spectroscopy on a Beckman IR2450 Spectrophotometer.

Intrinsic tear was measured on the compression molded sheet using the Elmendorf tear (type B) method as described in ASTM D-1922.

15 The slope of strain hardening is measured by compression molding a plaque from the polymer to be tested. Typically, the plaque is molded at about 177°C for 4 minutes under almost no pressure and then pressed for 3 minutes under a pressure of about 200 psi. The plaque is then allowed to cool at about 8°C/minute while still under 200 psi pressure. The molded plaque has a thickness of about 0.005 inches. The plaque is then cut into a dogbone shaped 20 test piece using a steel rule die. The test piece is 0.315 inches wide and 1.063 inches long. The start of the curved portion of the dogbone shape begins at 0.315 inches from each end of the sample and gently curves (that is, tapers) to a width of 0.09 inches. The curve ends at a point 0.118 inches from the start of the curve such that the interior portion of the dogbone test piece has a width of 25 0.09 inches and a length of 0.197 inches.

The tensile properties of the test sample is tested on an Instron Tensile Tester at a crosshead speed of 1 inch/minute. The slope of strain hardening is calculated from the resulting tensile curve by drawing a line parallel to the strain hardening region of the resulting stress/strain curve. The strain hardening

region occurs after the sample has pulled its initial load (( that is , stress) usually with little or no elongation during the intial load) and after the sample has gone through a slight drawing stage (usually with little or no increase in load, but with increasing elongation ( that is , strain)). In the strain hardening 5 region, the load and the elongation of the sample both continue to increase. The load increases in the strain hardening region at a much lower rate than during the intial load region and the elongation also increase, again at a rate lower than that experienced in the drawing region. The slope of the parallel line in the strain hardening region is then determined.

10 The slope of strain hardening coefficient (SHC) is calculated according to the following equation:

$$SHC = (\text{slope of strain hardening}) * (I_2)^{0.25}$$

where  $I_2$  = melt index in grams/10 minutes.

In one aspect of the present invention, there is provided an ethylene 15 copolymer comprising a copolymer of ethylene with at least one comonomer selected from the group consisting of a compound represented by the formula  $H_2C = CHR$  wherein R is a  $C_1 - C_{20}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4-C_{20}$  linear, branched or cyclic diene, prepared by a process copolymerizing said ethylene with said comonomer by slurry 20 polymerization in the presence of a solid catalyst system comprising: a support, a transition metal compound, and an activator capable of converting the transition metal compound into a catalytically active transition metal complex; and wherein said ethylene copolymer has the following properties (1) to (5):

(1) a density  $d$  ( $g/cm^3$ ) of from 0.870 to 0.980;  
25 (2) an  $M_w/M_n$  of from 2.5 to 10, wherein  $M_w$  and  $M_n$  are, respectively, a weight average molecular weight and a number average molecular weight, both as measured by gel permeation chromatography (GPC), in addition, the  $M_w/M_n$  satisfies the following inequalities;

$$1.25 \log M_w - 2.5 \leq M_w/M_n \leq 3.5 \log M_w - 11.0;$$

(3) when, in cross fractionation chromatography (CFC) of the ethylene copolymer, with respect to extraction at an arbitrary temperature  $T(^{\circ}C)$  falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is  $10^{\circ}C$  higher than the first temperature, the relationship between the arbitrary temperature  $T(^{\circ}C)$  and a point in molecular weight on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature  $T(^{\circ}C)$  at which point in molecular weight the molecular weight distribution profile of the copolymer fraction shows a peak having a maximum intensity is treated by the least squares method to obtain an approximate straight line, the approximate straight line has a gradient within the range defined by the formula (I):

15

$$-1 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.005 \quad (I)$$

wherein:

$T^1$  and  $T^2$  are two different arbitrary extraction temperatures  $T(^{\circ}C)$  within the range of between the first temperature and the second temperature, and  $M_p(T^1)$  and  $M_p(T^2)$  are, respectively, molecular weights corresponding to  $T^1$  and  $T^2$  on the approximate straight line; and

(4) the measurement of the ethylene copolymer by CFC shows characteristics such that the sum of respective amounts of copolymer fractions extracted at temperatures which are at least  $10^{\circ}C$  lower than the first temperature as defined above is 8% by weight or less, based on the total amount of, excluding purge, copolymer fractions extracted at temperatures in the

overall range of extraction temperatures in CFC;

(5) within a range in molecular weight of the ethylene copolymer which is defined by the formula (II):

5  $\log(M_t) - \log(M_c) \leq 0.5$  (II)

wherein:

M<sub>t</sub> is a point in molecular weight on a molecular weight distribution profile at which the profile shows a peak having a maximum intensity, 10 and

M<sub>c</sub> is an arbitrary point in molecular weight on the molecular weight distribution profile; and

the molecular weight distribution profile is obtained together with a comonomer content distribution profile by subjecting the ethylene 15 copolymer to gel permeation chromatography/Fourier transformation infrared spectroscopy (GPC/FT-IR), wherein

an approximate straight line obtained from the comonomer content distribution profile by the least squares method has a gradient within the range defined by the formula (III):

20  $0.0005 \leq \{C(M_c^1) - C(M_c^2)\} / (\log M_c^1 - \log M_c^2) \leq 0.05$  (III)

wherein:

M<sub>c</sub><sup>1</sup> and M<sub>c</sub><sup>2</sup> are two different arbitrary points (M<sub>c</sub>) in molecular weight which satisfy the formula (II), and

25 C(M<sub>c</sub><sup>1</sup>) and C(M<sub>c</sub><sup>2</sup>) are, respectively, comonomer contents corresponding to M<sub>c</sub><sup>1</sup> and M<sub>c</sub><sup>2</sup> on the approximate straight line.

The ethylene copolymer of the present invention defined above is a

novel ethylene copolymer having advantages in that it not only contains substantially no impurities such as a wax, a gel, but also has excellent properties, such as high impact strength and excellent environmental stress cracking resistance.

5        In another aspect of the present invention, there is provided a process for producing the ethylene copolymer comprising a copolymer of ethylene with at least one comonomer selected from the group consisting of a compound represented by the formula  $H_2C = CHR$  wherein R is a  $C_1 - C_{20}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or 10 cyclic diene, which process comprises copolymerizing said ethylene with said comonomer by slurry polymerization in the presence of a solid catalyst system comprising: a support, a transition metal compound, and an activator capable of converting the transition metal compound into a catalytically active transition metal complex wherein said solid catalyst system comprises;

15        1) a supported catalyst component comprising (a) a support material, an organometal compound wherein the metal is selected from Groups 2-13 of the Periodic Table of the Elements, germanium, tin, and lead, and (b) an activator compound comprising (b-1) a cation which is capable of reacting with a transition metal compound to form a catalytically active transition metal 20 complex, and (b-2) a compatible anion having up to 100 nonhydrogen atoms and containing at least one substituent comprising an active hydrogen moiety; and

25        2) a transition metal compound.

In still another aspect of the present invention, there is provided a process for producing the above-defined ethylene copolymer, wherein the transition metal compound contains at least one cyclic or noncyclic  $\pi$ -bonded anionic ligand group.

The ethylene copolymer of the present invention is a copolymer of ethylene with at least one comonomer selected from the group consisting of a compound represented by the formula  $H_2C = CHR$  wherein R is a  $C_1 - C_{20}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or cyclic diene.

The ethylene copolymer of the present invention has a density d ( $g/cm^3$ ) of from 0.870 to 0.980. Ethylene copolymers having a density d of lower than 0.870  $g/cm^3$  cannot be produced very well by slurry polymerization. On the other hand, when an ethylene copolymer has a density d ( $g/cm^3$ ) of higher than 10 0.980, the comonomer content of such a copolymer is too low, so that it is likely that the copolymer has substantially the same properties as those of an ethylene homopolymer, but does not have various excellent properties characteristic of a copolymer having a density d ( $g/cm^3$ ) within the above-defined range. In the present invention, it is preferred that the ethylene 15 copolymer have a density d ( $g/cm^3$ ) of from 0.87 to 0.980, more preferably from 0.890 to 0.965, and most preferably from 0.915 to 0.955.

The ethylene copolymer of the present invention has an  $M_w/M_n$  of from 2.5 to 10, wherein  $M_w$  and  $M_n$  are, respectively, the weight average molecular weight and the number average molecular weight, both as measured by gel 20 permeation chromatography (GPC). The ratio  $M_w/M_n$  is used as a criterion for molecular weight distribution. In the present invention, when an ethylene copolymer has an  $M_w/M_n$  of smaller than 2.5, the molecular weight distribution of the copolymer is too narrow, so that it becomes difficult for the ethylene copolymer to have the specific comonomer content distribution characteristic 25 defined in the present invention. On the other hand, when an ethylene copolymer has an  $M_w/M_n$  of larger than 10, it is likely that the impact resistance of the copolymer becomes disadvantageously low. Further, in the

present invention, it is preferred that the ethylene copolymers have an  $M_w/M_n$  of from 2.8 to 8, more preferably from 3 to 7.

The ethylene copolymer in the present invention has a melt index, ( $I_2$ ), of from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably 5 from 0.01 to 3000 g/10min.

The  $I_{21.6}/I_2$  ratio of the ethylene copolymer of the present invention is from 15 to 65, preferably from 18 to 55, more preferably from 20 to 50, or an  $I_{10}/I_2$  ratio of from 5 to 30, preferably from 5 to 28, more preferably from 5.5 to 25.

With respect to the ethylene copolymer of the present invention, when, in cross fractionation chromatography (CFC) of the ethylene copolymer of the present invention, with respect to extraction at an arbitrary temperature  $T(^{\circ}C)$  falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is the lower temperature of either the temperature of 10°C higher than said first temperature or 96°C, the relationship between the arbitrary temperature  $T(^{\circ}C)$  and a point in molecular weight on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature  $T(^{\circ}C)$  at which point in molecular weight the molecular weight distribution profile of the copolymer fraction shows a peak having a maximum intensity is treated by the least squares method to obtain an approximate straight line within the range of between said first temperature and said second temperature ; if there is the copolymer fraction the amount of which is less than 1 % by weight on the total amount, excluding purge, of copolymer fraction extracted at temperatures in the overall range of extraction temperatures in CFC, the copolymer fraction can be excluded from the calculation for the approximate straight line; the approximate straight line has a gradient within the range defined by the formula(I):

$$-1 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.005 \quad (I)$$

wherein:

5         $T^1$  and  $T^2$  are two different arbitrary extraction temperatures  $T(^{\circ}C)$   
within the range of between the first temperature and the second  
temperature, and  
Mp( $T^1$ ) and Mp( $T^2$ ) are, respectively, molecular weights corresponding  
to  $T^1$  and  $T^2$  on said approximate straight line.

10      In the above formula (I), the term  $\{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2)$   
indicates a gradient of the above-mentioned approximate straight line.

15      In the present invention, the cross fraction chromatography (CFC) is  
conducted using CFC T-150A (manufactured and sold by Mitsubishi Kagaku  
Corp., Japan). The measurement by CFC is conducted as follows. 20 mg of a  
sample is dissolved in 20 ml of dichlorobenzene having a temperature of 140  
°C, to thereby obtain a solution of the sample. Then, 5 ml of the obtained  
solution is added to a TREF (temperature rising elution fractionation) column  
filled with glass beads, and the solution is allowed to cool to 0°C at a rate of 1  
°C/min. Subsequently, the solution is heated, so as to elevate the temperature  
20      of the solution at a rate of 1 °C/min, thereby extracting copolymer fractions.  
Then, the extracted copolymer fractions are subjected to gel permeation  
chromatography (GPC) using a GPC column Shodex AD806MS (manufactured  
and sold by Showa Denko K.K., Japan), followed by Fourier transformation  
infrared spectroscopy (FT-IR) using Nicolet Manga - IR spectrometer 550  
25      (manufactured and sold by Nicolet Co., Ltd., U.S.A.).  
With respect to further details of the method for conducting CFC,  
reference can be made to the catalogue attached to the above-mentioned CFC T-

150A.

With respect to conventional ethylene copolymers produced using a conventional Ziegler catalyst, the gradient  $\{\log M_p(T^1) - \log M_p(T^2)\}/(T^1 - T^2)$  is generally almost 0 or of a positive value. With respect to conventional ethylene copolymers produced using conventional metallocene catalysts which have recently been being put into practical use, the gradient  $\{\log M_p(T^1) - \log M_p(T^2)\}/(T^1 - T^2)$  is almost 0.

As already mentioned above, in the present invention, when, in cross fractionation chromatography (CFC) of the ethylene copolymer of the present invention, with respect to extraction at an arbitrary temperature  $T(^{\circ}C)$  falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is the lower temperature of either the temperature of  $10^{\circ}C$  higher than said first temperature or  $96^{\circ}C$ , the relationship between the arbitrary temperature  $T(^{\circ}C)$  and a point in molecular weight on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature  $T(^{\circ}C)$  at which point in molecular weight the molecular weight distribution profile of the copolymer fraction shows a peak having a maximum intensity is treated by the least squares method to obtain an approximate straight line, the approximate straight line has a gradient [ that is ,  $\{\log M_p(T^1) - \log M_p(T^2)\}/(T^1 - T^2)$  ] which has negative value. This means that the copolymer fraction extracted at a low temperature, that is , a low density copolymer fraction having a high comonomer content, has a higher molecular weight than that of the copolymer fraction extracted at a high temperature, that is , a high density copolymer fraction having a low comonomer content.

The ethylene copolymer of the present invention has a gradient  $[\{\log M_p(T^1) - \log M_p(T^2)\}/(T^1 - T^2)]$  which is considerably large in negative value

(within the range of from -0.005 to -1). This clearly indicates that, in the ethylene copolymer of the present invention, a copolymer fraction having a high comonomer content has a high molecular weight, contrary to the conventional ethylene copolymers, in which a copolymer fraction having a high 5 comonomer content typically has a low molecular weight.

Further, the ethylene copolymer of the present invention has a gradient  $[\{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2)]$  in negative value within a range of from -0.005 to -1. This indicates that the copolymers having copolymer fractions of widely varied comonomer contents and widely varied molecular weights can be 10 obtained within the above-mentioned range of the gradient, which copolymer fractions widely vary from a low molecular weight copolymer fraction having a low comonomer content, that is, a high density copolymer fraction having a low molecular weight, to a high molecular weight copolymer fraction having a high comonomer content, that is, a low density copolymer fraction having a 15 high molecular weight. The copolymers of the present invention, which have different comonomer contents, exhibit excellent miscibility to each other or one another. Therefore, in the present invention, the copolymers having different comonomer contents can be blended, so as to obtain a copolymer having desired properties, without occurrence of gel formation.

20 However, when the gradient  $[\{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2)]$  becomes too small, it becomes difficult to obtain a designed copolymer having a desired structure and properties. Therefore, in the present invention, the gradient must be -1 or more. Further, in the present invention, the gradient be preferably 25 within the range defined by the formula:

25

$$-0.5 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.007;$$

preferably,

$$-0.1 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.01;$$

more preferably,

5

$$-0.08 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.02;$$

wherein  $T^1$ ,  $T^2$ ,  $M_p(T^1)$  and  $M_p(T^2)$  are as defined for the formula (I).

When the ethylene copolymer of the present invention is measured by

- 10 CFC, the ethylene copolymer shows characteristics such that the sum of respective amounts of copolymer fractions extracted at temperatures which are at least 10°C lower than the first temperature as defined above is 8 % by weight or less, based on the total amount, excluding purge, of copolymer fractions extracted at temperatures in the overall range of extraction temperature in CFC.
- 15 In the present invention, the above-mentioned sum of respective amounts of copolymer fractions can be obtained from an integral curve showing the amounts of extracted copolymer fraction, relative to extraction temperatures.

On the other hand, when conventional ethylene copolymers, produced using a Ziegler-Natta catalyst, are measured by CFC, the ethylene copolymers 20 show characteristics such that a relatively large amount of copolymer fractions are extracted at temperatures which are at least 10°C lower than the first temperature as defined above, as shown by Comparative Examples 4 through 6. This indicates that such ethylene copolymers have a broad distribution of 25 composition and contains low molecular weight waxy components or extremely low density copolymer fractions.

Conventionally, it has been considered that the ethylene copolymers produced using metallocene catalysts, which have recently been being put into

practical use, have a narrow distribution in comonomer content. However, when some of such ethylene copolymers are subjected to CFC measurement, a considerably large amount of copolymer fractions are extracted within a wide range of temperatures which are at least 10°C lower than the first temperature 5 as defined above.

In the case of the ethylene copolymer of the present invention, the amount of such copolymer fractions extracted at temperatures which are at least 10°C lower than the first temperature as defined above are extremely small. Specifically, when the ethylene copolymer of the present invention is measured 10 by CFC, the ethylene copolymer shows characteristics such that the sum of respective amounts of copolymer fractions extracted at temperatures which are at least 10°C lower than the first temperature as defined above is 8% by weight or less, preferably 5% by weight or less, more preferably 3.5% by weight or less, based on the total amount of copolymer fractions extracted at temperatures 15 in the overall range of extraction temperatures in CFC, but excluding the purge.

Due to such an extremely small content of the copolymer fractions extracted at temperatures which are at least 10°C lower than the first temperature as defined above, the ethylene copolymer of the present invention has excellent properties, for example, a freedom of adverse effects caused by 20 the presence of waxy components and low density copolymer fractions. Further, in the present invention, it is possible to produce copolymers having a very low density and a very low molecular weight. Such copolymers can be advantageously mixed for providing a wide variety of mixtures, each comprising two or more different copolymer components having different 25 comonomer contents. Therefore, it becomes possible to design various mixtures having desired properties by the use of the above-mentioned copolymers having a very low density and a very low molecular weight. This is

very advantageous from the commercial point of view.

In the present invention, within a range in molecular weight of the ethylene copolymer which is defined by the formula (II):

5  $\log(M_t) - \log(M_c) \leq 0.5$  (II)

wherein:

10  $M_t$  is a point in molecular weight on a molecular weight distribution profile at which the profile shows a peak having a maximum intensity, and

15  $M_c$  is an arbitrary point in molecular weight on the molecular weight distribution profile,

the molecular weight distribution profile being obtained together with a comonomer content distribution profile by subjecting the ethylene copolymer to gel permeation chromatography/Fourier transformation infrared spectroscopy (GPC/FT-IR),

20 an approximate straight line obtained from the comonomer content distribution profile by the least squares method has a gradient within the range defined by the formula (III):

25  $0.0005 \leq \{C(M_c^1) - C(M_c^2)\} / (\log M_c^1 - \log M_c^2) \leq 0.05$  (III)

wherein:

$M_c^1$  and  $M_c^2$  are two different arbitrary points ( $M_c$ ) in molecular weight which satisfy the formula (II), and

25  $C(M_c^1)$  and  $C(M_c^2)$  are, respectively, comonomer contents corresponding to  $M_c^1$  and  $M_c^2$  on the approximate straight line.

As mentioned above, the molecular weight distribution profile and the

comonomer content distribution profile can be obtained by subjecting the ethylene copolymer to gel permeation chromatography/Fourier transformation infrared spectroscopy (GPC/FT-IR). In the present invention, the measurement by GPC is conducted using 150C ALC/GPC (manufactured and sold by Waters 5 Assoc. Co. U.S.A.), in which three columns [one Shodex AT-807S (manufactured and sold by Showa Denko K.K., Japan) and two TSK-gel GMH-H6 (manufactured and sold by Tosoh Corp., Japan)], which are connected in series, are used, and the measurement by FT-IR is conducted by dissolving 20 to 30mg of a sample in 15 ml of trichlorobenzene having a temperature of 140 10 °C, and applying 500 to 1,000 $\mu$ l of the resultant solution to a FT-IR apparatus (PERKIN-ELMER 1760X, manufactured and sold by Perkin Elmer Cetus, Co., Ltd., U.S.A.).

In the present invention, the comonomer content is defined as a value obtained by dividing the number of comonomer units relative to 1,000 15 methylene units contained in the copolymer, by 1,000. For example, when 5 comonomer units are contained relative to 1,000 methylene units, the comonomer content is 0.005. The value of the comonomer content can be obtained from the ratio of the intensity of an absorbance attributed to the comonomer units to the intensity of an absorbance attributed to the methylene 20 units, which ratio can be obtained by FT-IR. For example, when a linear  $\alpha$ -olefin is used as a comonomer, the ratio of the intensity of absorbance at 2,960  $\text{cm}^{-1}$ , which is attributed to the methyl groups, to the intensity of absorbance at 2,925  $\text{cm}^{-1}$ , which is attributed to the methylene groups, is obtained by FT-IR. From the obtained ratio, the comonomer content can be obtained.

25 Generally, the above-mentioned comonomer content distribution profile is shown as a line containing points indicating comonomer contents. For improving the accuracy of the profile, it is desirable to obtain a large number of

points indicating the comonomer contents by repeatedly conducting the comonomer content measurement using the same sample under the same conditions. In the present invention, within the above-defined range in molecular weight of the ethylene copolymer, an approximate straight line is 5 obtained from the obtained points of comonomer content distribution profile by the least squares method.

In the present invention, the gradient of the approximate straight line obtained from the comonomer content distribution profile is defined by the following formula:

10

$$\{C(Mc^1)-C(Mc^2)\}/(\log Mc^1-\log Mc^2)$$

wherein:

15  $Mc^1$  and  $Mc^2$  are two different arbitrary points (Mc) in molecular weight which satisfy the formula (II), and

$C(Mc^1)$  and  $C(Mc^2)$  are, respectively, comonomer contents corresponding to  $Mc^1$  and  $Mc^2$  on the approximate straight line.

20 The comonomer content distribution profile indicates the comonomer contents of copolymer fractions of various molecular weights, and the gradient of the approximate straight line obtained from the profile by the least squares method indicates the change in comonomer content, relative to the change in molecular weight of the copolymer fraction.

25 With respect to the ethylene copolymers produced using a conventional Ziegler catalyst, the above-mentioned gradient of the approximate straight line has a negative value. This indicates that such conventional ethylene copolymers have a comonomer content distribution such that the higher the molecular weight of a copolymer fraction, the lower the comonomer content of

the copolymer fraction.

Even in the case of ethylene copolymers produced using conventional metallocene catalysts which have recently been being put into practical use, the above-mentioned gradient of approximate straight line obtained from the 5 comonomer content distribution profile by the least squares method is almost 0. Even if the errors in measurement are considered, the gradient is smaller than 0.0001.

On the other hand, the ethylene copolymer of the present invention has the above-mentioned gradient  $\{\{C(Mc^1)-C(Mc^2)\}/(\log Mc^1-\log Mc^2)\}$  of 0.0005 10 or more, within the above-defined range in molecular weight of the ethylene copolymer.

This clearly indicates that the ethylene copolymer of the present invention has a specific comonomer content distribution such that, in one aspect, the lower the molecular weight of a copolymer fraction, the lower the 15 comonomer content of the copolymer fraction; and, in the other aspect, the higher the molecular weight of a copolymer fraction, the higher the comonomer content of the copolymer fraction. Due to such a specific comonomer content distribution, the ethylene copolymer of the present invention exhibits various excellent properties, such as high impact strength and excellent ESCR 20 properties, as compared to the conventional ethylene copolymers.

In the present invention, it is preferred that, within the above-defined range in molecular weight of the ethylene copolymer, the above-mentioned gradient be within the range defined by the formula (IV):

$$25 \quad 0.001 \leq \{\{C(Mc^1)-C(Mc^2)\}/(\log Mc^1-\log Mc^2)\} \leq 0.02 \quad (IV)$$

wherein  $Mc^1$ ,  $Mc^2$ ,  $C(Mc^1)$  and  $C(Mc^2)$  are as defined for the formula (III).

In the present invention, there is provided a process for obtaining a novel ethylene copolymer.

Specifically, the process comprises copolymerizing ethylene with at least one comonomer selected from the group consisting of a compound represented by the formula  $H_2C = CHR$  wherein R is a  $C_1 - C_{20}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or cyclic diene by slurry polymerization in the presence of a solid catalyst system comprising:

10 a support, a transition metal compound, and an activator capable of converting the transition metal compound into a catalytically active transition metal complex.

The reasons for obtaining the unexpected and surprising copolymer properties with the process of the present invention are believed to be as follows.

15 As already mentioned above, the ethylene copolymer of the present invention has a specific comonomer content distribution such that, in one aspect, the lower the molecular weight of a copolymer fraction, the lower the comonomer content of the copolymer fraction; and, in the other aspect, the higher the molecular weight of a copolymer fraction, the higher the comonomer 20 content of the copolymer fraction.

In addition, for producing the ethylene copolymer of the present invention, the following requirements have to be satisfied:

- (i) the produced polymer must not be melted in the reaction mixture but maintains the solid state;
- 25 (ii) the polymerization rate at the active species of the catalyst is satisfactorily high; and
- (iii) the active species of the catalyst is strongly associated with a carrier, so

that the active species of the catalyst is not liberated from the carrier and does not escape from the polymer being produced.

Further, the larger the particle size of a polymer being produced, the easier it becomes to achieve a comonomer content distribution characteristic of 5 the ethylene copolymer of the present invention, namely, a specific comonomer content distribution such that, in one aspect, the lower the molecular weight of a copolymer fraction, the lower the comonomer content of the copolymer fraction; and, in the other aspect, the higher the molecular weight of a copolymer fraction, the higher the comonomer content of the copolymer 10 fraction.

In the method of the present invention for producing an ethylene copolymer, the above-mentioned requirements are satisfied, so that the polymerization reaction can proceed as is explained below.

First, in the method of the present invention, the polymerization reaction 15 is conducted by slurry polymerization, so that the produced polymer is not melted, but maintains the solid state, during the reaction. Therefore, requirement (i) is satisfied.

Second, the preferred catalyst systems to be used in the present invention contain a transition metal compound, that is, a compound of a transition metal 20 of a Group selected from Groups 3 to 5 of the Periodic Table, wherein the compound contains at least one, preferably only one cyclic  $\pi$ -bonded anionic ligand. Such preferred transition metal compounds, having only one cyclic  $\pi$ -bonded anionic ligand, have a large space around the transition metal, as compared to the space around the transition metal of a metallocene catalyst 25 which contains two or more cyclic or non-cyclic  $\pi$ -bonded anionic ligands. Therefore, with respect to a transition metal compound having only one cyclic or non-cyclic  $\pi$ -bonded anionic ligand, the access of a bulky comonomer to the

transition metal is not inhibited, thus enabling the reaction to proceed smoothly. In addition, the preferred catalyst system to be used in the method of the present invention contains a solid component which serves to achieve a high polymerization rate. Therefore, with the catalyst system to be used in the 5 present invention, the rate of polymerization at the active species of the catalyst is satisfactorily high. Hence, the method of the present invention satisfies requirement (ii) above.

Third, in the preferred catalyst systems to be used in the present invention, the active species of the catalyst is strongly associated with a carrier, 10 so that the active species of the catalyst is not liberated from the carrier and does not escape from the polymer being produced.

Specifically stated, in one preferred supported catalyst component to be used in the process of the present invention, the active hydrogen moiety of the activator compound may be bonded to the hydroxyl groups of the support 15 material through an organometal compound. That is, the activator compound is strongly bonded to and carried on the support material. In a further preferred supported catalyst component to be used in the present invention, alumoxane is fixed to the support material by a heating and/or washing treatment, such that the alumoxane is substantially not extractable under severe conditions (toluene 20 at 90 °C). Therefore, requirement (iii) above is met.

The ethylene copolymer of the present invention can be advantageously produced by the method of the present invention using the catalyst system described above, and the catalytic system is especially effective when a catalyst has a relatively large particle size and when the bulk of the comonomer is 25 relatively large.

As described above, the production of the ethylene copolymer of the present invention is enabled only when all of the above-mentioned requirements

are simultaneously satisfied. The present inventors have for the first time unexpectedly found the above-mentioned requirements for the production of the excellent ethylene copolymer of the present invention.

Hereinbelow, the method for producing the ethylene copolymer of the 5 present invention will be explained in more detail.

The ethylene copolymer of the present invention is advantageously produced by copolymerizing ethylene with a comonomer using a specific solid catalyst.

Suitable support materials for use in the present invention include porous 10 resinous materials, for example, polyolefins such as polyethylenes and polypropylenes or copolymers of styrene-divinylbenzene, and solid inorganic oxides including oxides of Group 2, 3, 4, 13, or 14 metals, such as silica, alumina, magnesium oxide, titanium oxide, thorium oxide, as well as mixed oxides of silica. Suitable mixed oxides of silica include those of silica and one 15 or more Group 2 or 13 metal oxides, such as silica-magnesia or silica-alumina mixed oxides. Silica, alumina, and mixed oxides of silica and one or more Group 2 or 13 metal oxides are preferred support materials. Preferred examples of such mixed oxides are the silica-aluminas. The most preferred support material is silica. The shape of the silica particles is not critical and the silica 20 may be in granular, spherical, agglomerated, fumed or other form. Suitable silicas include those that are available from Grace Davison (division of W.R. Grace & Co.) under the designations SD 3216.30, SP-9-10046, Davison Syloid<sup>TM</sup> 245, Davison 948 and Davison 952, from Degussa AG under the designation Aerosil<sup>TM</sup> 812, and from Crossfield under the designation ES 70X.

25 Support materials suitable for the present invention preferably have a surface area as determined by nitrogen porosimetry using the B.E.T. method from 10 to 1000 m<sup>2</sup>/g, and preferably from 100 to 600 m<sup>2</sup>/g. The pore volume

of the support, as determined by nitrogen adsorption, is typically up to 5 cm<sup>3</sup>/g, advantageously between 0.1 and 3 cm<sup>3</sup>/g, preferably from 0.2 to 2 cm<sup>3</sup>/g. The average particle size is not critical but typically is from 0.5 to 500 µm, preferably from 1 to 200 µm, more preferably to 100 µm.

5        The support material may be subjected to a heat treatment and/or chemical treatment to reduce the water content or the hydroxyl content of the support material. Both dehydrated support materials and support materials containing small amounts of water can be used. Typical thermal pretreatments are carried out at a temperature from 30°C to 1000°C for a duration of 10 minutes to 50 hours in an inert atmosphere or under reduced pressure. Typical support materials have a surface hydroxyl content of from 0.1 micromol, preferably from 5 micromol, more preferably from 0.05 mmol to not more than 10 mmol and preferably not more than 5 mmol hydroxyl groups per g of solid support, more preferably from 0.5 to 2 mmol per gram. The hydroxyl content 10      15      20      25      can be determined by known techniques, such as infrared spectroscopy and titration techniques using a metal alkyl or metal hydroxide, for example, adding an excess of dialkyl magnesium to a slurry of the solid support and determining the amount of dialkyl magnesium remaining in solution via known techniques. This latter method is based on the reaction of



wherein S is the solid support.

As an alternative technique for measuring the amount of hydroxyl groups on the surface of the inorganic solid, a method comprising the following procedures can be utilized. Illustratively stated, the inorganic solid is dried in a nitrogen gas flow at 250 °C for 10 hours and then, the weight of the dried inorganic solid is measured and taken as an initial weight represented by "W1" (unit: g). After this, the dried inorganic solid is heated to 1,000 °C and then, allowed to

cool to the room temperature. The weight of the cooled inorganic solid is measured, and the difference between the initial weight (W1) and the weight of the cooled inorganic solid is determined and taken as a weight loss represented by " $\Delta W$ " (unit: g). The amount of the hydroxyl groups was calculated by the  
5 following formula:

$$\text{Amount of the hydroxyl groups} = (1,000 \times \Delta W / 18.02) / W1 \text{ mmol/g (V)}$$

It is preferred that the inorganic solid having hydroxyl groups on the surface thereof to be used in the method of the present invention does not contain water such as crystal water or adsorbed water.

10 Any water contained in the inorganic solid can be removed therefrom by heating in a nitrogen atmosphere or under reduced pressure at 250 °C or more for 1 hour or more.

15 Suitable transition metal compounds for use in the present invention are those that can be converted by an activator compound (b) to thereby form a catalytically active transition metal complex. The transition metal compounds may be derivatives of any transition metal including Lanthanides, preferably from Groups 3, 4, 5, and 6, more preferably the Group 3 or 4 transition metals or the Lanthanides, which transition metals are in the +2, +3, or +4 formal oxidation state. The transition metals preferably contain at least one  $\pi$ -bonded  
20 anionic ligand group which can be a cyclic or noncyclic delocalized  $\pi$ -bonded anionic ligand group. Exemplary of such  $\pi$ -bonded anionic ligand groups are conjugated or non-conjugated, cyclic or non-cyclic dienyl groups, allyl groups, aryl groups, as well as substituted derivatives of such groups.

25 The term "derivative" when used to describe the above-substituted, delocalized  $\pi$ -bonded groups means that each atom in the delocalized  $\pi$ -bonded group may independently be substituted with a radical selected from the group consisting of halogen, hydrocarbyl, halohydrocarbyl, and hydrocarbyl-

substituted metalloid radicals wherein the metalloid is selected from Group 14 of the Periodic Table of the Elements. Included within the term "hydrocarbyl" are C<sub>1</sub>-20 straight, branched and cyclic alkyl radicals, C<sub>6</sub>-20 aromatic radicals, C<sub>7</sub>-20 alkyl-substituted aromatic radicals, and C<sub>7</sub>-20 aryl-substituted alkyl radicals. In addition two or more such radicals may together form a fused ring system or a hydrogenated fused ring system. Suitable hydrocarbyl-substituted organo-metalloid radicals include mono-, di- and tri-substituted organo-metalloid radicals of Group 14 elements wherein each of the hydrocarbyl groups contains from 1 to 20 carbon atoms. More particularly, suitable hydrocarbyl-substituted organo-metalloid radicals include trimethylsilyl, triethylsilyl, ethyldimethylsilyl, methyldiethylsilyl, triphenylgermyl, trimethylgermyl.

Preferred anionic, delocalized  $\pi$ -bonded groups include cyclopentadienyl and substituted cyclopentadienyl groups. Especially preferred are cyclopentadienyl, indenyl, fluorenyl, tetrahydroindenyl, tetrahydrofluorenyl, and octahydrofluorenyl. Other examples of preferred anionic ligand groups are pentadienyl, cyclohexa dienyl, dihydroanthracenyl, hexahydroanthracenyl, and decahydroanthracenyl groups, and methyl-substituted derivatives thereof.

Suitable transition metal compounds (c) may be a cyclopentadienyl or substituted cyclopentadienyl derivative of any transition metal including Lanthanides, but preferably of the Group 3, 4, or Lanthanide transition metals. Suitable transition metal compounds for use in the present invention are the bridged or unbridged mono-, bis-, and tri-cyclopentadienyl or substituted cyclopentadienyl transition metal compounds.

Suitable unbridged monocyclopentadienyl or mono(substituted cyclopentadienyl) transition metal derivatives are represented by the following formula (VI):



wherein Cp is cyclopentadienyl or a derivative thereof, M is a Group 3, 4, or 5 transition metal having a formal oxidation state of +2, +3 or +4, X

5 independently in each occurrence represents an anionic ligand group (other than a cyclic, aromatic  $\pi$ -bonded anionic ligand group) selected from the group of hydrocarbyl, hydrocarbylene (including hydrocarbadienyl), hydrocarbyloxy, hydride, halo, silyl, germyl, amide, and siloxy radicals having up to 50 nonhydrogen atoms, and n, a number equal to one less than the formal oxidation

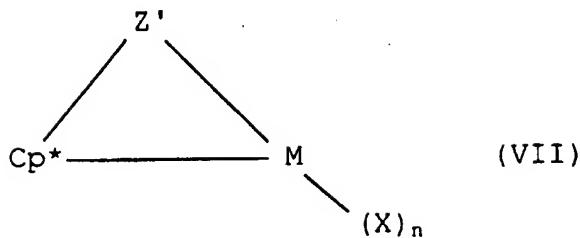
10 state of M, is 1, 2 or 3. preferably 3. Preferably, at least one of X is a hydrocarbyl radical having from 1 to 20 carbon atoms, a substituted-hydrocarbyl radical having from 1 to 20 carbon atoms wherein one or more of the hydrogen atoms are replaced with a halogen atom, or an organo-metallocloid radical comprising a Group 14 element wherein each of the hydrocarbyl

15 substituents contained in the organo portion of said organo-metallocloid, independently, contain from 1 to 20 carbon atoms.

Suitable bridged monocyclopentadienyl or mono(substituted cyclopentadienyl) transition metal compounds include the so-called constrained geometry complexes. Examples of such complexes and methods for their

20 preparation are disclosed in U.S. Application Serial No. 545,403, filed July 3, 1990 (corresponding to EP-A-416,815), U.S. Application Serial No. 241,523, filed May 12, 1994 (corresponding to WO-95/00526), as well as U.S. Patents 5,055,438, 5,057,475. 5,096,867, 5,064,802 5,132,380, and 5,374,696 all of which are incorporated herein by reference.

25 More particularly, preferred bridged monocyclopentadienyl or mono(substituted cyclopentadienyl) transition metal compounds correspond to the following formula (VII):



wherein:

M is a metal of Group 3-5, especially a Group 4 metal, particularly  
5 titanium:

Cp\* is a substituted cyclopentadienyl group bound to Z' and, in an  $\eta^5$  bonding mode, to M or such a group is further substituted with from one to four substituents selected from the group consisting of hydrocarbyl, silyl, germyl, halo, hydrocarbyloxy, amine, and mixtures thereof, said substituent having up to 20 nonhydrogen atoms, or optionally, two such further substituents together cause Cp\* to have a fused ring structure;  
10

Z' is a divalent moiety other than a cyclic or noncyclic  $\pi$ -bonded anionic ligand, said Z' comprising boron, or a member of Group 14 of the Periodic Table of the Elements, and optionally nitrogen, phosphorus, sulfur or oxygen, said moiety having up to 20 non-hydrogen atoms, and  
15 optionally Cp\* and Z' together form a fused ring system;

X independently each occurrence represents an anionic ligand group (other than a cyclic, aromatic  $\pi$ -bonded anionic ligand group) selected from the group of hydrocarbyl, hydrocarbylene (including hydrocarbadienyl), hydrocarbyloxy, hydride, halo, silyl, germyl, amide, and siloxy radicals having up to 50 nonhydrogen atoms, preferably X is selected from the group of a hydride radical, hydrocarbyl radical,  
20

substituted-hydrocarbyl radical, or organo-metalloid radical; and  
n is 1 or 2 depending on the valence of M.

In consonance with the previous explanation, M is preferably a Group 4 metal, especially titanium; n is 1 or 2; and X is monovalent ligand group of up to 30 nonhydrogen atoms, more preferably, C<sub>1-20</sub> hydrocarbyl.

When n is 1 and the Group 3-5 metal (preferably the Group 4 metal) is in the +3 formal oxidation state, X is preferably a stabilizing ligand.

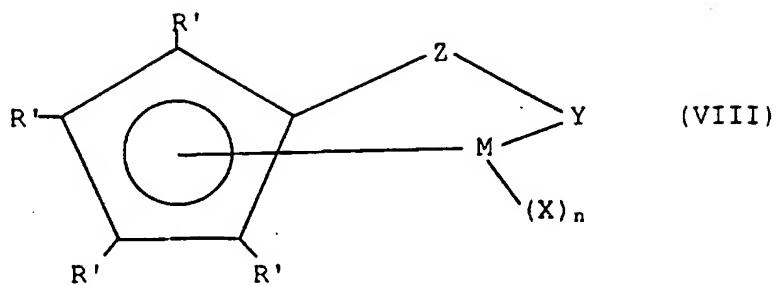
By the term "stabilizing ligand" is meant that the ligand group stabilizes the metal complex through either:

10 1) a nitrogen, phosphorus, oxygen or sulfur chelating bond, or  
2) an  $\eta^3$  bond with a resonant, delocalized  $\pi$ -electronic structure.

Examples of stabilizing ligands of group 1) include silyl, hydrocarbyl, amido or phosphido ligands substituted with one or more aliphatic or aromatic ether, thioether, amine or phosphine functional groups, especially such amine 15 or phosphine groups that are tertiary-substituted, said stabilizing ligand having from 3 to 30 nonhydrogen atoms. Most preferred group 1) stabilizing ligands are 2-dialkylaminobenzyl or 2-(dialkylaminomethyl)-phenyl groups containing from 1 to 4 carbons in the alkyl groups.

Examples of stabilizing ligands of group 2) include C<sub>3-10</sub> hydrocarbyl 20 groups containing ethylenic unsaturation, such as allyl, 1-methylallyl, 2-methylallyl, 1,1-dimethylallyl, or 1,2,3-trimethylallyl groups.

More preferably still, such metal coordination complexes correspond to the following formula (VIII):



wherein R' in each occurrence is independently selected from the group consisting of hydrogen, hydrocarbyl, silyl, germyl, cyano, halo and combinations thereof having up to 20 nonhydrogen atoms, or two R' groups together form a divalent derivative thereof;

5

X has the same meaning as defined for formula (VI);

10

Y is a divalent anionic ligand group comprising nitrogen, phosphorus, oxygen or sulfur and having up to 20 non-hydrogen atoms, said Y being bonded to Z and M through said nitrogen, phosphorus, oxygen or sulfur, and optionally Y and Z together form a fused ring system;

M is a Group 4 metal, especially titanium;

Z is  $\text{SiR}^*_2$ ,  $\text{CR}^*_2$ ,  $\text{SiR}^*_2\text{SiR}^*_2$ ,  $\text{CR}^*_2\text{CR}^*_2$ ,  $\text{CR}^*=\text{CR}^*$ ,  $\text{CR}^*_2\text{SiR}^*_2$ ,  $\text{GeR}^*_2$ ,  $\text{BR}^*$ , or  $\text{BR}^*_2$ ; wherein:

15

$\text{R}^*$  in each occurrence is independently selected from the group consisting of hydrogen, hydrocarbyl, silyl, halogenated alkyl, halogenated aryl groups having up to 20 non-hydrogen atoms, and mixtures thereof, or two or more R\* groups from Z, or an R\* group from Z together with Y form a fused ring system; and

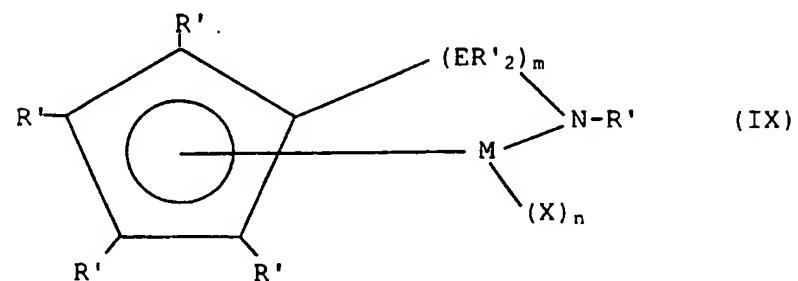
n is 1 or 2.

20

Further more preferably, Y is  $-\text{O}-$ ,  $-\text{S}-$ ,  $-\text{NR}^*-$ ,  $-\text{PR}^*-$ . Highly preferably Y is a nitrogen or phosphorus containing group corresponding to the formula  $-\text{N}(\text{R}')-$  or  $-\text{P}(\text{R}')-$ , wherein R' is as previously described, that is, an amido or

phosphido group.

Most highly preferred metal coordination complexes correspond to the following formula (IX):



5

wherein:

M is titanium;

R' each occurrence is independently selected from the group consisting of hydrogen, silyl, hydrocarbyl and combinations thereof having up to 10 carbon or silicon atoms, or two R' groups of the substituted cyclopentadienyl moiety are joined together;

E is silicon or carbon;

X independently each occurrence is hydride, alkyl, aryl, of up to 10 carbons;

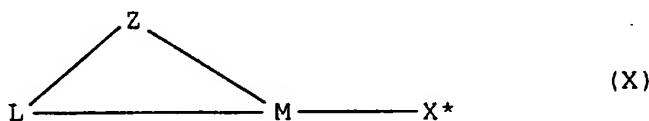
15 m is 1 or 2; and

n is 1 or 2.

Examples of the above most highly preferred metal coordination compounds include compounds wherein the R' on the amido group is methyl, ethyl, propyl, butyl, pentyl, hexyl, (including isomers), norbornyl, benzyl, 20 phenyl, and cyclododecyl; (ER'2)m is dimethyl silane or 1,2-ethylene; R' on the cyclic  $\pi$ -bonded group independently each occurrence is hydrogen, methyl, ethyl, propyl, butyl, pentyl, hexyl, norbornyl, benzyl, and phenyl, or two R' groups are joined forming an indenyl, tetrahydroindenyl, fluorenyl or

octahydrofluorenyl moiety; and X is methyl, ethyl, propyl, butyl, pentyl, hexyl, norbornyl, benzyl, and phenyl.

Transition metal compounds wherein the transition metal is in the +2 formal oxidation state include those complexes containing one and only one 5 cyclic, delocalized, anionic,  $\pi$ -bonded group, said complexes corresponding to the following formula (X):



wherein:

10      M is titanium or zirconium in the +2 formal oxidation state;

      L is a group containing a cyclic, delocalized, anionic,  $\pi$ -system through which the group is bonded to M, and which group is also bonded to Z;

15      Z is a moiety bonded to M via a  $\sigma$ -bond, comprising boron, or a member of Group 14 of the Periodic Table of the Elements, and also comprising nitrogen, phosphorus, sulfur or oxygen, said moiety having up to 60 non-hydrogen atoms; and

      X\* is a neutral, conjugated or nonconjugated diene, optionally substituted with one or more hydrocarbyl groups, said X having up to 40 carbon atoms and forming a  $\pi$ -complex with M.

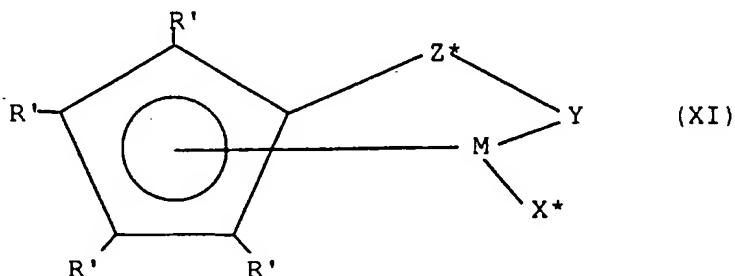
20      Preferred transition metal compounds of formula (X) include those wherein Z, M and X\* are as previously defined; and L is a C<sub>5</sub>H<sub>4</sub> group bonded to Z and bound in an  $\eta^5$  bonding mode to M or is such an  $\eta^5$  bound group substituted with from one to four substituents independently selected from

25      hydrocarbyl, silyl, germyl, halo, cyano, and combinations thereof, said

substituent having up to 20 nonhydrogen atoms, and optionally, two such substituents (except cyano or halo) together cause a fused ring structure.

More preferred transition metal +2 compounds according to the present invention correspond to the following formula (XI)):

5



wherein:

R' in each occurrence is independently selected from hydrogen, hydrocarbyl, silyl, germyl, halo, cyano, and combinations thereof, said R' having up to 20 nonhydrogen atoms, and optionally, two R' groups (where R' is not hydrogen, halo or cyano) together form a divalent derivative thereof connected to adjacent positions of the cyclopentadienyl ring to form a fused ring structure;

X\* is a neutral  $\eta^4$ -bonded diene group having up to 30 nonhydrogen atoms, which forms a  $\pi$ -complex with M;

Y is -O-, -S-, -NR\*-, -PR\*-;

M is titanium or zirconium in the +2 formal oxidation state;

Z\* is  $\text{SiR}^*_2$ ,  $\text{CR}^*_2$ ,  $\text{SiR}^*_2\text{SiR}^*_2$ ,  $\text{CR}^*_2\text{CR}^*_2$ ,  $\text{CR}^*=\text{CR}^*$ ,  $\text{CR}^*_2\text{SiR}^*_2$ , or  $\text{GeR}^*_2$ ; wherein:

R\* each occurrence is independently hydrogen, or a member selected from hydrocarbyl, silyl, halogenated alkyl, halogenated aryl, and combinations thereof, said R\* having up to 10 nonhydrogen atoms, and optionally, two R\* groups from Z\* (when R\* is not hydrogen), or an R\*

group from Z\* and an R\* group from Y form a ring system.

Preferably, R' independently each occurrence is hydrogen, hydrocarbyl, silyl, halo and combinations thereof said R' having up to 10 nonhydrogen atoms, or two R' groups (when R' is not hydrogen or halo) together form a 5 divalent derivative thereof; most preferably, R' is hydrogen, methyl, ethyl, propyl, butyl, pentyl, hexyl, (including where appropriate all isomers), cyclopentyl, cyclohexyl, norbornyl, benzyl, or phenyl or two R' groups (except hydrogen) are linked together. the entire C,R', group thereby being, for example, an indenyl, tetrahydroindenyl, fluorenyl, tetrahydrofluorenyl, or 10 octahydrofluorenyl group.

Further preferably, at least one of R' or R\* is an electron donating moiety. By the term "electron donating" is meant that the moiety is more electron donating than hydrogen. Thus, highly preferably Y is a nitrogen or phosphorus containing group corresponding to the formula -N(R")- or -P(R")-, 15 wherein R" is C<sub>1-10</sub> hydrocarbyl.

Examples of suitable X\* groups include: s-trans- $\eta^4$ -1,4-diphenyl-1,3-butadiene; s-trans- $\eta^4$ -3-methyl-1,3-pentadiene; s-trans- $\eta^4$ -1,4-dibenzyl-1,3-butadiene; s-trans- $\eta^4$ -2,4-hexadiene; s-trans- $\eta^4$ -1,3-pentadiene; s-trans- $\eta^4$ -1,4-ditolyl-1,3-butadiene; s-trans- $\eta^4$ -1,4-bis(trimethylsilyl)-1,3-butadiene; s-cis- $\eta^4$ -1,4-diphenyl-1,3-butadiene; s-cis- $\eta^4$ -3-methyl-1,3-pentadiene; s-cis- $\eta^4$ -1,4-dibenzyl-1,3-butadiene; s-cis- $\eta^4$ -2,4-hexadiene; s-cis- $\eta^4$ -1,3-pentadiene; s-cis- $\eta^4$ -1,4-ditolyl-1,3-butadiene; and s-cis- $\eta^4$ -1,4-bis(trimethylsilyl)-1,3-butadiene, 20 said s-cis diene group forming a  $\pi$ -complex as defined herein with the metal.

Most highly preferred transition metal +2 compounds are amidosilane- or 25 amidoalkanediyl- compounds of formula (XI) wherein:  
-Z\*-Y- is -(ER'')<sub>m</sub>-N(R")-, and R' each occurrence is independently selected from hydrogen, silyl, hydrocarbyl and combinations thereof, said R'

having up to 10 carbon or silicon atoms, or two such R' groups on the substituted cyclopentadienyl group (when R' is not hydrogen) together form a divalent derivative thereof connected to adjacent positions of the cyclopentadienyl ring;

5 R" is C<sub>1-10</sub> hydrocarbyl;  
 R''' is independently each occurrence hydrogen or C<sub>1-10</sub> hydrocarbyl;  
 E is independently each occurrence silicon or carbon; and  
 m is 1 or 2.

Examples of the metal complexes according to the present invention  
 10 include compounds wherein R" is methyl, ethyl, propyl, butyl, pentyl, hexyl, (including all isomers of the foregoing where applicable), cyclododecyl, norbornyl, benzyl, or phenyl; (ER"')<sub>m</sub> is dimethylsilane, or ethanediyl; and the cyclic delocalized  $\pi$ -bonded group is cyclopentadienyl, tetramethylcyclopentadienyl, indenyl, tetrahydroindenyl, fluorenyl, tetrahydrofluorenyl or  
 15 octahydrofluorenyl.

Suitable bis(cyclopentadienyl) derivatives of transition metals include those of titanium, zirconium and hafnium compounds and may be represented by the following general formulae (XII) to (XV):

(A-Cp) MX <sub>1</sub> X <sub>2</sub>	(XII)
(A-Cp) MX' <sub>1</sub> X' <sub>2</sub>	(XIII)
(A-Cp) ML	(XIV)
(Cp*) (CpR) MX <sub>1</sub>	(XV)

20

wherein: M is a Group 4 metal namely titanium (Ti), zirconium (Zr) and hafnium (Hf); (A-Cp) is either (Cp)(Cp\*) or Cp-A'-Cp\* and Cp and Cp\* are the same or different cyclopentadienyl radicals, as well as substituted derivatives of

cyclopentadienyl radicals, and A' is a covalent bridging group containing a Group 14 element; L is an olefin, diolefin or aryne ligand; at least one of X<sub>1</sub> and X<sub>2</sub> is a hydride radical, hydrocarbyl radical, substituted-hydrocarbyl radical, or organo-metalloid radical, the other of X<sub>1</sub> and X<sub>2</sub> being a hydride radical, hydrocarbyl radical, substituted-hydrocarbyl radical, organo-metalloid radical, or a hydrocarbyloxy radical; preferably one or both of X<sub>1</sub> and X<sub>2</sub> is a hydrocarbyl radical having from 1 to 20 carbon atoms, substituted-hydrocarbyl radical having from 1 to 20 carbon atoms wherein one or more of the hydrogen atoms are replaced with a halogen atom, organo-metalloid radical comprising a 5 Group 14 element wherein each of the hydrocarbyl substituents contained in the organo portion of said organo-metalloid, independently, contain from 1 to 20 carbon atoms; X'<sub>1</sub> and X'<sub>2</sub> are joined and bound to the metal atom to form a metallacycle, in which the metal, X'<sub>1</sub> and X'<sub>2</sub> form a hydrocarbocyclic ring 10 containing from 3 to 20 carbon atoms; and R is a substituent, preferably a hydrocarbyl substituent, having from 1 to 20 carbon atoms on one of the 15 cyclopentadienyl radicals, which is also bound to the metal atom.

When not both X<sub>1</sub> and X<sub>2</sub> are a hydride radical, hydrocarbyl radical, substituted-hydrocarbyl radical, or organo-metalloid radical one of these can be a hydrocarbyloxy radical having from 1 to 20 carbon atoms. Suitable examples 20 of hydrocarbyloxy radicals include alkyloxy, aryloxy, aralkyloxy, and alkaryloxy radicals having from 1 to 20 carbon atoms, more preferably alkyl radicals having from 1 to 6 carbon atoms, and aryl, aralkyl and alkaryl radicals having from 6 to 10 carbon atoms, even more preferably isopropoxy, n-butyloxy, or t-butyloxy.

25 Examples of such bis(cyclopentadienyl) derivatives of transition metals and methods for their preparation are disclosed in U.S. Patent 5,384,299 (corresponding to EP-A-277,004) and U.S. Application Serial No. 459,921,

filed January 2, 1990 (corresponding to WO-91/09882), which are incorporated herein by reference.

Suitable tri-cyclopentadienyl or substituted cyclopentadienyl transition metal compounds include those containing a bridging group linking two 5 cyclopentadienyl groups and those without such bridging groups.

Suitable unbridged tri-cyclopentadienyl transition metal derivatives are represented by the following formula (XVI):



wherein Cp, M and X are as defined for formula (VI) and n'' is three less than 10 the formal oxidation state of M and is 0 or 1, preferably 1. Preferred ligand groups X are hydrocarbyl, hydrocarbyloxy, hydride, halo, silyl, germyl, amide, and siloxy.

According to one preferred embodiment, the solid (or supported) catalyst comprises:

15 a supported catalyst component comprising (a) a support material, and an organometal compound wherein the metal is selected from Groups 2-13 of the Periodic Table of the Elements, germanium, tin, and lead, and (b) an activator compound comprising (b-1) a cation which is capable of reacting with a transition metal compound to form a catalytically active transition metal complex, and (b-2) a compatible anion having up to 100 nonhydrogen atoms 20 and containing at least one substituent comprising an active hydrogen moiety; and

a transition metal compound.

The support material is typically treated with the organometal 25 compound. Suitable organometal compounds are those comprising metals of Groups 2-13, germanium, tin, and lead, and at least two substituents selected from hydride, hydrocarbyl radicals, trihydrocarbyl silyl radicals, and

trihydrocarbyl germyl radicals. Additional substituents preferably comprise one or more substituents selected from hydride, hydrocarbyl radicals, trihydrocarbyl substituted silyl radicals, trihydrocarbyl substituted germyl radicals, and hydrocarbyl-, trihydrocarbyl silyl- or trihydrocarbyl germyl-  
5 substituted metalloid radicals.

The recitation "metalloid", as used herein, includes non-metals such as boron, phosphorus which exhibit semi-metallic characteristics.

Examples of such organometal compounds include organomagnesium, organozinc, organoboron, organoaluminum, organogermanium, organotin, and  
10 organolead compounds, and mixtures thereof. Further suitable organometal compounds are alumoxanes. Preferred examples are alumoxanes and compounds represented by the following formulae:  $MgR^1_2$ ,  $ZnR^1_2$ ,  $BR^1_xR^2_y$ ,  $AIR^1_xR^2_y$ , wherein  $R^1$  independently each occurrence is hydride, a hydrocarbyl radical, a trihydrocarbyl silyl radical, a trihydrocarbyl germyl radical, or a trihydrocarbyl-, trihydrocarbyl silyl-, or trihydrocarbyl germyl-  
15 substituted metalloid radical,  $R^2$  independently is the same as  $R^1$ ,  $x$  is 2 or 3,  $y$  is 0 or 1 and the sum of  $x$  and  $y$  is 3, and mixtures thereof. Examples of suitable hydrocarbyl moieties are those having from 1 to 20 carbon atoms in the hydrocarbyl portion thereof, such as alkyl, aryl, alkaryl, or aralkyl. Preferred  
20 radicals include methyl, ethyl, n- or i-propyl, n-, s- or t-butyl, phenyl, and benzyl. Preferably, the aluminum component is selected from the group consisting of alumoxane and aluminum compounds of the formula  $AIR^1_x$  wherein  $R^1$  in each occurrence independently is hydride or a hydrocarbyl radical having from 1 to 20 carbon atoms, and  $x$  is 3. Suitable trihydrocarbyl  
25 aluminum compounds are trialkyl or triaryl aluminum compounds wherein each alkyl or aryl group has from 1 to 10 carbon atoms, or mixtures thereof, and preferably trialkyl aluminum compounds such as trimethyl, triethyl, tri-isobutyl

aluminum.

Alumoxanes (also referred to as aluminoxanes) are oligomeric or polymeric aluminum oxy compounds containing chains of alternating aluminum and oxygen atoms, whereby the aluminum carries a substituent, preferably an alkyl group. The structure of alumoxane is believed to be represented by the following general formulae  $(-Al(R)-O)_m$ , for a cyclic alumoxane, and  $R_2Al-O(-Al(R)-O)_m-AlR_2$ , for a linear compound, wherein R independently in each occurrence is a  $C_1-C_{10}$  hydrocarbyl, preferably alkyl, or halide and m is an integer ranging from 1 to 50, preferably at least 4. Alumoxanes are typically the reaction products of water and an aluminum alkyl, which in addition to an alkyl group may contain halide or alkoxide groups. Reacting several different aluminum alkyl compounds, such as, for example, trimethyl aluminum and tri-isobutyl aluminum, with water yields so-called modified or mixed alumoxanes. Preferred alumoxanes are methylalumoxane and methylalumoxane modified with minor amounts of other lower alkyl groups such as isobutyl. Alumoxanes generally contain minor to substantial amounts of starting aluminum alkyl compound.

The way in which the alumoxane is prepared is not critical. When prepared by the reaction between water and aluminum alkyl, the water may be combined with the aluminum alkyl in various forms, such as liquid, vapor, or solid, for example in the form of crystallization water. Particular techniques for the preparation of alumoxane type compounds by contacting an aluminum alkyl compound with an inorganic salt containing water of crystallization are disclosed in U.S. Patent 4,542,199. In a particular preferred embodiment an aluminum alkyl compound is contacted with a regeneratable water-containing substance such as hydrated alumina, silica or other substance. This is disclosed in European Patent Application No. 338,044.

The supported catalyst according to this embodiment generally comprises a support material combined or treated with the organometal compound and containing at least 0.1 micromol of organometal compound per g of support material, typically at least 5 micromole per g support material,

5 advantageously at least 0.5 weight percent of the metal, preferably aluminum, expressed in gram of metal atoms per g of support material. Preferably, the amount of metal is at least 2 weight percent, and generally not more than 40 weight percent, and more preferably not more than 30 weight percent. At too high amounts of metal the supported catalyst becomes expensive. At too low amounts the catalyst efficiency goes down to drop below acceptable levels.

10

The supported catalysts preferably contains a treated support material (a) comprising a support material and an alumoxane wherein not more than 10 percent aluminum present in the treated support material is extractable in a one hour extraction with toluene of 90°C using about 10 mL toluene per gram of

15 pretreated support material. More preferably, not more than 9 percent aluminum present in the supported catalyst component is extractable, and most preferably not more than 8 percent. This is especially advantageous when the supported catalyst is used in a polymerization process where a diluent or solvent is used which may extract non-fixed alumoxane from the support

20 material. It has been found that when the amount of extractables is below the levels given above, the amount of alumoxane that can diffuse into the polymerization solvent or diluent, if used, is so low that no appreciable amount of polymer will be formed in the diluent, as compared to polymer formed on the support material. If too much polymer is formed in the diluent the polymer

25 bulk density will decrease below acceptable levels and reactor fouling problems may occur.

The toluene extraction test is carried out as follows: About 1 g of

supported catalyst component or supported catalyst, with a known aluminum content, is added to 10 mL toluene and the mixture is then heated to 90°C under an inert atmosphere. The suspension is stirred well at this temperature for 1 hour. Then the suspension is filtered applying reduced pressure to assist in the 5 filtration step. The solids are washed twice with about 3 to 5 mL toluene of 90°C per gram of solids. The solids are then dried at 120°C for 1 hour, and subsequently the aluminum content of the solids is measured. The difference between the initial aluminum content and the aluminum content after the extraction divided by the initial aluminum content and multiplied by 100%, 10 gives the amount of extractable aluminum.

The aluminum content can be determined by slurring about 0.5 g of supported catalyst component or supported catalyst in 10 mL hexane. The slurry is treated with 10 to 15 mL 6N sulfuric acid, followed by addition of a known excess of EDTA. The excess amount of EDTA is then back-titrated with 15 zinc chloride.

Without wishing to be bound by any theory, it is believed that the activator compound according to this embodiment reacts with the organometal compound through the active hydrogen-containing substituent. It is believed that a group  $R^1$  of the organometal compound combines with the active 20 hydrogen moiety of the activator compound to release a neutral organic compound, for example an alkane, or hydrogen gas thereby chemically coupling the metal atom with the activator compound residue. Thus the activator is believed to become chemically attached to the support material once the support material has been treated with the organometal compound or adduct of 25 organometal compound and activator compound. Upon addition of the transition metal compound a supported catalyst is formed having improved properties.

The activator compound useful in the present invention contains a compatible anion having up to 100, and preferably up to 50 nonhydrogen atoms and having at least one substituent comprising an active hydrogen moiety. Preferred substituents comprising an active hydrogen moiety correspond to the 5 formula (XVII):

$G_q(T-H)_r$  (XVII):

wherein G is a polyvalent hydrocarbon radical, T is O, S, NR, or PR, wherein R is a hydrocarbyl radical, a trihydrocarbyl silyl radical, a trihydrocarbyl germyl radical, or hydrogen. , q is 0 or 1, and preferably 1, and r is an integer from 1 to 10 3, preferably 1. Polyvalent hydrocarbon radical G has  $r+1$  valencies, one valency being with a metal or metalloid of the Groups 5-15 of the Periodic Table of the Elements in the compatible anion, the other valency or valencies of G being attached to r groups T-H. Preferred examples of G include divalent 15 hydrocarbon radicals such as: alkylene, arylene, aralkylene, or alkarylene radicals containing from 1 to 20 carbon atoms, more preferably from 2 to 12 carbon atoms. Suitable examples of G include phenylene, biphenylene, naphthylene, methylene, ethylene, 1,3-propylene, 1,4-butylene, phenylmethylene ( $-C_6H_4-CH_2-$ ). The polyvalent hydrocarbyl portion G may be 20 further substituted with radicals that do not interfere with the coupling function of the active hydrogen moiety. Preferred examples of such non-interfering substituents are alkyl, aryl, alkyl- or aryl-substituted silyl and germyl radicals, and fluoro substituents.

The group T-H in the previous formula thus may be an -OH, -SH, -NRH, 25 or -PRH group, wherein R preferably is a C<sub>1-18</sub>, preferably a C<sub>1-10</sub> hydrocarbyl radical or hydrogen, and H is hydrogen. Preferred R groups are alkyls, cycloalkyls, aryls, arylalkyls, or alkylaryls of 1 to 18 carbon atoms,

more preferably those of 1 to 12 carbon atoms. The -OH, -SH, -NRH, or -PRH groups may be part of a larger functionality such as, for example, C(O)-OH, C(S)-SH, C(O)-NRH, and C(O)-PRH. Most preferably, the group T-H is a hydroxy group, -OH, or an amino group, -NRH.

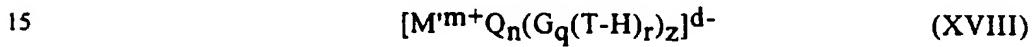
5       Very preferred substituents  $G_q(T-H)_r$  comprising an active hydrogen moiety include hydroxy- and amino-substituted aryl, aralkyl, alkaryl or alkyl groups, and most preferred are the hydroxyphenyls, especially the 3- and 4-hydroxyphenyl groups, hydroxytolyls, hydroxy benzyls (hydroxymethylphenyl), hydroxybiphenyls, hydroxynaphthyls, hydroxycyclohexyls, hydroxymethyls, 10 and hydroxypropyls, and the corresponding amino-substituted groups, especially those substituted with -NRH wherein R is an alkyl or aryl radical having from 1 to 10 carbon atoms, such as for example methyl, ethyl, propyl, i-propyl, n-, i-, or t-butyl, pentyl, hexyl, heptyl, octyl, nonyl, and decyl, phenyl, benzyl, tolyl, xylol, naphthyl, and biphenyl.

15       The compatible anion containing the substituent which contains an active hydrogen moiety, may further comprise a single Group 5-15 element or a plurality of Group 5-15 elements, but is preferably a single coordination complex comprising a charge-bearing metal or metalloid core, which anion is bulky. A compatible anion specifically refers to an anion which when 20 functioning as a charge balancing anion in the catalyst system of this invention, does not transfer an anionic substituent or fragment thereof to the transition metal cation thereby forming a neutral transition metal compound and a neutral metal by-product. "Compatible anions" are anions which are not degraded to neutrality when the initially formed complex decomposes and are 25 noninterfering with desired subsequent polymerizations.

Preferred anions are those containing a single coordination complex comprising a charge-bearing metal or metalloid core carrying a substituent

containing an active hydrogen moiety which anion is relatively large (bulky), capable of stabilizing the active catalyst species (the transition metal cation) which is formed when the activator compound and transition metal compound are combined and said anion will be sufficiently labile to be displaced by 5 olefinic, diolefinic and acetylenically unsaturated compounds or other neutral Lewis bases such as ethers, nitriles . Suitable metals for the anions of activator compounds include, but are not limited to, aluminum, gold, platinum . Suitable metalloids include, but are not limited to, boron, phosphorus, silicon . Activator compounds which contain anions comprising a coordination complex 10 containing a single boron atom and a substituent comprising an active hydrogen moiety are preferred.

Preferably, compatible anions containing a substituent comprising an active hydrogen moiety may be represented by the following general formula (XVIII):



wherein:

M' is a metal or metalloid selected from Groups 5-15 of the Periodic Table of the Elements;

20 Q independently in each occurrence is selected from the group consisting of hydride, dihydrocarbylamido, preferably dialkylamido, halide, hydrocarbyloxide, preferably alkoxide and aryloxide, hydrocarbyl, and substituted-hydrocarbyl radicals, including halo-substituted hydrocarbyl radicals, and hydrocarbyl- and halohydrocarbyl-substituted organo-metalloid radicals, the hydrocarbyl portion having from 1 to 20 25 carbons with the proviso that in not more than one occurrence is Q halide;

G is a polyvalent, having r+1 valencies and preferably divalent hydrocarbon radical bonded to M' and T;

T is O, S, NR, or PR, wherein R is a hydrocarbon radical, a trihydrocarbyl silyl radical, a trihydrocarbyl germyl radical, or hydrogen;

m is an integer from 1 to 7, preferably 3;

n is an integer from 0 to 7, preferably 3;

5 q is an integer 0 or 1, preferably 1;

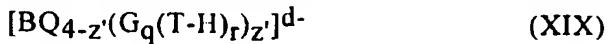
r is an integer from 1 to 3, preferably 1;

z is an integer from 1 to 8, preferably 1;

d is an integer from 1 to 7, preferably 1; and

n+z-m = d.

10 Preferred boron-containing anions which are particularly useful in this invention may be represented by the following general formula (XIX):



wherein:

15 B is boron in a valence state of 3;

z' is an integer from 1-4, preferably 1;

d is 1; and

Q, G, T, H, q, and r are as defined for formula (XVIII). Preferably, z' is 1, q is 1, and r is 1.

Illustrative, but not limiting, examples of anions of activator compounds 20 to be used in the present invention are boron-containing anions such as triphenyl(hydroxyphenyl)borate, diphenyl-di(hydroxyphenyl)borate, triphenyl(2,4-dihydroxyphenyl)borate, tri(p-tolyl)(hydroxyphenyl)borate, tris-(pentafluorophenyl)(hydroxyphenyl)borate, tris-(2,4-dimethylphenyl)(hydroxyphenyl)borate, tris-(3,5-dimethylphenyl)(hydroxyphenyl)borate, tris-(3,5-di-25 trifluoromethylphenyl)(hydroxyphenyl)borate, tris(pentafluorophenyl)(2-hydroxyethyl)borate, tris(pentafluorophenyl)(4-hydroxybutyl)borate, tris(pentafluorophenyl)(4-hydroxycyclohexyl)borate, tris(pentafluorophenyl)(4-

(4'-hydroxyphenyl)phenyl)borate, tris(pentafluorophenyl)(6-hydroxy-2-naphthyl)borate, . A highly preferred activator complex is tris(pentafluorophenyl)(4-hydroxyphenyl) borate. Other preferred anions of activator compounds are those above mentioned borates wherein the hydroxy functionality is replaced by an amino NHR functionality wherein R preferably is methyl, ethyl, or t-butyl.

The cationic portion (b-1) of the activator compound to be used in association with the compatible anion (b-2) can be any cation which is capable of reacting with the transition metal compound to form a catalytically active transition metal complex, especially a cationic transition metal complex. The cations (b-1) and the anions (b-2) are used in such ratios as to give a neutral activator compound. Preferably the cation is selected from the group consisting of Brønsted acidic cations, carbonium cations, silylum cations, and cationic oxidizing agents.

Brønsted acidic cations may be represented by the following general formula:



wherein:

L is a neutral Lewis base, preferably a nitrogen, phosphorus, or sulfur containing Lewis base; and  $(L-H)^+$  is a Brønsted acid. The Brønsted acidic cations are believed to react with the transition metal compound by transfer of a proton of said cation, which proton combines with one of the ligands on the transition metal compound to release a neutral compound.

Illustrative, but not limiting, examples of Brønsted acidic cations of activator compounds to be used in the present invention are trialkyl-substituted ammonium cations such as triethylammonium, tripropylammonium, tri(n-

butyl)ammonium, trimethylammonium, tributylammonium, and tri(n-octyl)ammonium. Also suitable are N,N-dialkyl anilinium cations such as N,N-dimethylanilinium, N,N-diethylanilinium, N,N-2,4,6-pentamethylanilinium, N,N-dimethylbenzylammonium ; dialkylammonium cations such as di-(i-propyl)ammonium, dicyclohexylammonium ; and triarylphosphonium cations such as triphenylphosphonium, tri(methylphenyl)phosphonium, tri(dimethylphenyl)phosphonium, dimethylsulphonium, diethylsulphonium, and diphenylsulphonium.

A second type of suitable cation corresponds to the formula:

10

 $\textcircled{C}^+$ 

wherein  $\textcircled{C}^+$  is a stable carbonium or silylium ion containing up to 30 nonhydrogen atoms. the cation being capable of reacting with a substituent of the transition metal compound and converting it into a catalytically active transition metal complex, especially a cationic transition metal complex.

15

Suitable examples of cations include tropyllium, triphenylmethylium, benzene(diazonium). Silylium salts have been previously generically disclosed in J. Chem. Soc. Chem. Comm., 1993, 383-384, as well as Lambert, J.B.. et. al., Organometallics, 1994, 13, 2430-2443. Preferred silylium cations are triethylsilylium, and trimethylsilylium and ether substituted adducts thereof.

20

Another suitable type of cation comprises a cationic oxidizing agent represented by the formula:

 $\text{Ox}^{e+}$ 

wherein  $\text{Ox}^{e+}$  is a cationic oxidizing agent having a charge of  $e+$ , and  $e$  is an integer from 1 to 3.

25

Examples of cationic oxidizing agents include: ferrocenium, hydrocarbyl-substituted ferrocenium,  $\text{Ag}^+$ , and  $\text{Pb}^{2+}$ .

The quantity of activator compound in the supported catalyst component

and the supported catalyst is not critical, but typically ranges from 0.1, preferably from 1 to 2,000 micromoles of activator compound per gram of treated support material. Preferably, the supported catalyst or component contains from 10 to 1,000 micromoles of activator compound per gram of 5 treated support material.

Generally, the ratio of moles of activator compound (b) to gramatoms of transition metal in compound (c) in the supported catalyst is from 0.05:1 to 100:1, preferably from 0.5:1 to 20:1 and most preferably from 1:1 to 5:1 mole activator compound per gramatom of transition metal in the transition metal 10 compound. At too low ratios the supported catalyst will not be very active, whereas at too high ratios the catalyst becomes less economic due to the relatively high cost associated with the use of large quantities of activator compound.

The supported catalyst according to this embodiment can be prepared by 15 combining the support material with the organometal compound and the activator compound. The order of addition is not critical. The organometal compound may be either first combined with the support material or with the activator compound, and subsequently the activator compound or the support material may be added. One preferred embodiment comprises treating the 20 support material first with the organometal compound by combining the organometal compound in a suitable solvent, such as a hydrocarbon solvent, with the support material. The temperature, pressure, and contact time for this treatment are not critical, but generally vary from -20°C to 150 °C, from subatmospheric to 10 bar, more preferably at atmospheric pressure, for 5 25 minutes to 48 hours. Usually the slurry is agitated. After this treatment the solids are typically separated from the solvent. Any excess of organometal compound could then be removed by techniques known in the art. This method

is especially suitable for obtaining support material with relatively low metal loadings.

According to a preferred embodiment, the support material is first subjected to a thermal treatment at 100°C to 1000 °C, preferably at 200°C to 5 850 °C. Typically, this treatment is carried out for 10 minutes to 72 hours, preferably from 0.5 hours to 24 hours. Then the thermally treated support material is combined with the organometal compound, preferably AlR'3 wherein R' has the meaning defined hereinbefore in a suitable diluent or solvent, preferably one in which the organometal compound is soluble. Typical 10 solvents are hydrocarbon solvents having from 5 to 12 carbon atoms, preferably aromatic solvents such as toluene and xylenes, or aliphatic solvents of 6 to 10 carbon atoms, such as hexane, heptane, octane, nonane, decane, and isomers thereof, cycloaliphatic solvents of 6 to 12 carbon atoms such as cyclohexane, or mixtures of any of these.

15 The support material is combined with the organometal compound at a temperature of -20°C to 150 °C, preferably at 20°C to 100 °C. The contact time is not critical and can vary from 5 minutes to 72 hours, and is preferably from 0.5 hours to 36 hours. Agitation is preferably applied. The thus treated support material is then preferably contacted with the activator compound.

20 An alternative treatment of the support material, suitable for obtaining alumoxane loadings attached to the support material, involves one or both of the following steps A and B:

A. heating a support material containing alumoxane under an inert atmosphere for a period and at a temperature sufficient to fix alumoxane to the 25 support material;

B. subjecting the support material containing alumoxane to one or more wash steps to remove alumoxane not fixed to the support material;

thereby selecting the conditions in heating step A and washing step B so as to form a treated support material wherein not more than 10 percent aluminum present in the treated support material is extractable in a one hour extraction with toluene of 90°C using about 10 mL toluene per gram of supported catalyst component. High amounts of alumoxane attached to the support material are obtained using first heating step A., optionally followed by wash step B.

In this process the alumoxane treated support material may be obtained by combining in a diluent an alumoxane with a support material containing from zero to not more than 20 weight percent of water, preferably from zero to 10 not more than 6 weight percent of water, based on the total weight of support material and water. The alumoxane desirably is used in a dissolved form.

Alternatively, the alumoxane pretreated support material may be obtained by combining in a diluent, a support material containing from 0.5 to 15 50 weight percent water, preferably from 1 to 20 weight percent water, based on the total weight of support material and water, with a compound of the formula R"<sup>n</sup>\*AlX"<sup>3-n</sup>\* wherein R" in independently each occurrence is a hydrocarbyl radical. X" is halogen or hydrocarbyloxy, and n\* is an integer from 1 to 3. Preferably, n\* is 3. R" in independently each occurrence is preferably an alkyl radical, advantageously one containing from 1 to 12 carbon atoms. Preferred 20 alkyl radicals are methyl, ethyl, propyl, isopropyl, n-butyl, isobutyl, tert-butyl, pentyl, iso-pentyl, hexyl, iso-hexyl, heptyl, octyl, and cyclohexyl. Highly preferred compounds of formula R"<sup>n</sup>\*AlX"<sup>3-n</sup>\* are trimethylaluminum, triethylaluminum and tri-isobutylaluminum. When the alumoxane is prepared *in situ* by reacting the compound of the formula R"<sup>n</sup>\*AlX"<sup>3-n</sup>\* with water, the 25 mole ratio of R"<sup>n</sup>\*AlX"<sup>3-n</sup>\* to water is typically 10:1 to 1:1, preferably from 5:1 to 1:1.

The support material is added to the alumoxane or compound of the

formula  $R''_n*AlX''_{3-n}*$ , preferably dissolved in a solvent, most preferably a hydrocarbon solvent, or the solution of alumoxane or compound of the formula  $R''_n*AlX''_{3-n}*$  is added to the support material. The support material can be used as such in dry form or slurried in a hydrocarbon diluent. Both aliphatic and aromatic hydrocarbons can be used. Suitable aliphatic hydrocarbons include, for example, pentane, isopentane, hexane, heptane, octane, iso-octane, nonane, isononane, decane, cyclohexane, methylcyclohexane and combinations of two or more of such diluents. Suitable examples of aromatic diluents are benzene, toluene, xylene, and other alkyl or halogen-substituted aromatic compounds. Most preferably, the diluent is an aromatic hydrocarbon, especially toluene. Suitable concentrations of solid support in the hydrocarbon medium range from 0.1 to 15, preferably from 0.5 to 10, more preferably from 1 to 7 weight percent. The contact time and temperature are not critical. Preferably the temperature is from 0°C to 60 °C, more preferably from 10°C to 40 °C. The contact time is from 15 minutes to 40 hours, preferably from 1 to 20 hours.

Before subjecting the alumoxane-treated support material to the heating step or washing step, the diluent or solvent is preferably removed to obtain a free flowing powder. This is preferably done by applying a technique which only removes the liquid and leaves the aluminum compounds on the solid, such as by applying heat, reduced pressure, evaporation, or a combination thereof. If desired, the removal of diluent can be combined with the heating step, although care should be taken that the diluent is removed gradually.

The heating step and/or the washing step are conducted in such a way that a very large proportion (more than about 90 percent by weight) of the alumoxane which remains on the support material is fixed. Preferably, a heating step is used, more preferably a heating step is used followed by a

washing step. When used in the preferred combination both steps cooperate such that in the heating step the alumoxane is fixed to the support material, whereas in the washing step the alumoxane which is not fixed is removed to a substantial degree. The upper temperature for the heat-treatment is preferably 5 below the temperature at which the support material begins to agglomerate and form lumps which are difficult to redisperse, and below the alumoxane decomposition temperature. When the transition metal compound c) is added before the heat treatment, the heating temperature should be below the decomposition temperature of the transition metal compound. Preferably, the 10 heat-treatment is carried out at a temperature from 90°C to 250°C for a period from 15 minutes to 24 hours. More preferably, the heat treatment is carried out at a temperature from 160°C to 200°C for a period from 30 minutes to 4 hours. Good results have been obtained while heating for 8 hours at 100°C as well as while heating for 2 hours at 175 °C. By means of preliminary experiments, a 15 person skilled in the art will be able to define the heat-treatment conditions that will provide the desired result. It is also noted, that the longer the heat treatment takes, the higher the amount of alumoxane fixed to the support material will be. The heat-treatment is carried out at reduced pressure or under an inert atmosphere, such as nitrogen gas, or both but preferably at reduced 20 pressure. Depending on the conditions in the heating step, the alumoxane may be fixed to the support material to such a high degree that a wash step may be omitted.

In the wash step, the number of washes and the solvent used are such that sufficient amounts of non-fixed alumoxane are removed. The washing 25 conditions should be such that non-fixed alumoxane is soluble in the wash solvent. The support material containing alumoxane, preferably already subjected to a heat-treatment, is preferably subjected to one to five wash steps

using an aromatic hydrocarbon solvent at a temperature from 0°C to 110 °C.

More preferably, the temperature is from 20°C to 100 °C. Preferred examples of aromatic solvents include toluene, benzene and xylenes. More preferably, the aromatic hydrocarbon solvent is toluene. At the end of the wash treatment,

- 5 the solvent is removed by a technique that also removes the alumoxane dissolved in the solvent, such as by filtration or decantation. Preferably, the wash solvent is removed to provide a free flowing powder.

The organometal compound treated support material is then typically reslurried in a suitable diluent and combined with the activator compound. The 10 activator compound is preferably used in a diluent. Suitable diluents include hydrocarbon and halogenated hydrocarbon diluents. Any type of solvent or diluent can be used which does not react with the catalyst components in such a way as to negatively impact the catalytic properties. Preferred diluents are aromatic hydrocarbons, such as toluene, benzene, and xylenes, and aliphatic 15 hydrocarbons such as hexane, heptane, and cyclohexane. Preferred halogenated hydrocarbons include methylene chloride and carbon tetrachloride. The temperature is not critical but generally varies between -20 °C and the decomposition temperature of the activator. Typical contact times vary from a few minutes to several days. Agitation of the reaction mixture is preferred.

20 Advantageously, the activator compound is dissolved, using heat to assist in dissolution where desired. It may be desirable to carry out the contacting between the organometal-treated support material and the activator compound at elevated temperatures. Preferably, such elevated temperatures are from 45 °C to 120 °C.

25 Instead of first treating the support material with the organometal compound, preferably aluminum component, and subsequently adding the activator compound, the organometal compound, preferably aluminum

component, and activator compound may be combined in a suitable diluent prior to adding or combining the reaction mixture to or with the support material.

Without wishing to be bound by any theory, it is believed that an organo 5 group of the organometal compound reacts with the active hydrogen moiety contained in the activator anion (b-2) to form a reaction or contact product (hereinafter also referred to as "adduct"). For example, when the organometal compound is trialkylaluminum  $AlR_3$  and the active hydrogen-containing moiety is represented by G-OH, the reaction product is believed to comprise G-O- $AlR_2$  10 whereas further an alkane by-product RH is formed. This adduct G-O- $AlR_2$  when combined with the support material containing hydroxyl groups, Si-OH in case of a silica support material, is believed to form Si-O- $Al(R)-O-G$  together with alkane RH as by-product. This method of preparing the supported catalyst component has been found to run very smoothly and to provide catalysts and 15 catalyst precursors or components having desirable properties. Typical ratios to be used in this reaction are from 1:1 to 20:1 moles of organometal compound to mole equivalents of active hydrogen moieties contained in the activator anion (b-2).

The amount of adduct, formed by combining the organometal compound 20 with the activator compound, to be combined with the support material is not critical. Preferably, the amount is not higher than can be fixed to the support material. Typically, this is determined by the amount of support material hydroxyls. The amount of adduct to be employed is preferably not more than the equivalent amount of such hydroxyl groups. Less than the equivalent 25 amount is preferably used, more preferably the ratio between moles of adduct to moles of surface reactive groups such as hydroxyls is between 0.01 and 1, even more preferably between 0.02 and 0.8. Prior to adding the transition metal

compound it is preferred, especially when less than an equivalent amount of adduct is added with respect to surface reactive groups, to add an additional amount of organometal compound to the reaction product of support material and the adduct to remove any remaining surface reactive groups which

5 otherwise may react with the transition metal and thus require higher amounts thereof to achieve equal catalytic activity. Prior to combining it with the transition metal compound, the supported catalyst component can be washed, if desired, to remove any excess of adduct or organometal compound.

The supported catalyst component comprising the support material,

10 organometal compound, and the activator may be isolated to obtain a free flowing powder by removing the liquid medium using preferably filtration or evaporation techniques.

Although the transition metal compound may be combined with the activator compound, or the adduct of the organometal compound and the

15 activator compound, prior to combining the activator compound or its adduct with the support material, this results in reduced catalyst efficiencies.

Preferably, the transition metal is first combined with the support material treated with the organometal component and before adding the activator compound, or the transition metal is added after the treated support material

20 and activator have been combined, or after the activator adduct and the support material have been combined. Most preferably, the transition metal compound (c) is added to the reaction product of the support material treated with the organometal compound and activator compound, or after the activator adduct and the support material have been combined.

25 The transition metal compound is preferably used dissolved in a suitable solvent, such as a hydrocarbon solvent, advantageously a C<sub>5</sub>-10 aliphatic or cycloaliphatic hydrocarbon or a C<sub>6</sub>-10 aromatic hydrocarbon. The contact

temperature is not critical provided it is below the decomposition temperature of the transition metal and of the activator. Good results are obtained in a temperature range of 0 °C to 100 °C. All steps in the present process should be conducted in the absence of oxygen and moisture.

5       Upon combining the transition metal compound with the supported catalyst component, the supernatant liquid typically is colorless indicating that the transition metal compound, which solution typically is colored, substantially remains with the solid supported catalyst.

According to an alternative preferred embodiment the solid (or  
10      supported) catalyst comprises:

      a supported catalyst component comprising a support material and an alumoxane wherein not more than 10 percent aluminum present in the supported catalyst component is extractable in a one hour extraction with toluene of 90°C using 10 ml toluene per gram of supported catalyst  
15      component;

      and a transition metal compound.

      This solid catalyst according to this embodiment may be used in the absence of the activator compound (b) comprising (b-1) a cation which is capable of reacting with a transition metal compound to form a catalytically active transition metal complex, and (b-2) a compatible anion having up to 100 nonhydrogen atoms and containing at least one substituent comprising an active hydrogen moiety.

      According to this alternative embodiment, the aluminum atom (from the alumoxane component) to transition metal atom mole ratio in the supported catalyst generally is from 1 to 5000, preferably from 25 to 1000 and most preferably from 50 to 500.

      The quantity of transition metal compound in the supported catalyst of

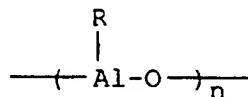
the present invention is not critical, but typically ranges from 0.1 to 1000 micromoles of transition metal compound per gram of support material. Preferably, the supported catalyst contains from 1 to 250 micromoles of transition metal compound per gram of support material.

5 The supported catalyst according to this embodiment is obtainable by heating and/or washing a support material containing alumoxane under an inert atmosphere for a period and at a temperature sufficient to fix alumoxane to the support material, as discussed above.

It may be advantageous to use in the present process the solid catalyst in 10 association with impurity scavengers which serve to protect the solid catalyst from catalyst poisons such as water, oxygen, and polar compounds. Preferred compounds for this purpose include an organoaluminum compound represented by the following formula:



15 wherein R is a C<sub>1</sub>-C<sub>20</sub> hydrocarbyl group; X is a halogen atom or a C<sub>1</sub>-C<sub>20</sub> hydrocarbyloxy group; and n is a positive integer selected from 1 to 3, or an organoaluminuoxo compound represented by the following formula:



20 wherein R is a C<sub>1</sub>-C<sub>20</sub> hydrocarbyl group; and n is a positive integer selected from 5 to 50.

By the treatment with the organoaluminum compound or the organoaluminuoxo compound, the resistance of the solid catalyst system to impurities, such as water, oxygen which are present in the solid catalyst system, can be improved, and the solid catalyst system can be stored for a prolonged period of time.

In the above treatment, the organoaluminum compound or the organoaluminuoxo compound is used preferably in an amount of 0.1 to 100mol in terms of aluminum, more preferably in an amount of 1 to 30mol, per mol of a transition metal compound contained in the solid catalyst system. It is 5 noted that the organoaluminuoxo compound should preferably not be used in amount that may cause desorption of the transition metal compound from the solid catalyst.

The solid catalyst system to be used in the method of the present invention can be stored in the form of a slurry thereof in an inert hydrocarbon 10 solvent, or dried and stored in a solid form thereof.

When a copolymerization reaction for producing the ethylene copolymer of the present invention is conducted using the solid catalyst system, it is important that the copolymerization reaction be performed under conditions such that the reaction rate is limited by independent diffusion of each of the 15 polymerization participants (such as hydrogen, ethylene and at least one comonomer) into the ethylene copolymer being formed. For this purpose, the copolymerization reaction must be conducted under conditions such that the ethylene copolymer being formed around the solid catalyst system is not melted or dissolved in the reaction system.

20 For realizing the above-mentioned polymerization reaction conditions, the copolymerization reaction is conducted by slurry polymerization.

By conducting slurry polymerization under the above-mentioned reaction conditions, as long as the reaction conditions are appropriately controlled, the ethylene copolymer being formed around the solid catalyst system is not melted 25 or dissolved during the polymerization reaction, but maintains a powdery form (which powdery form is achieved by the use of the above-mentioned specific catalyst system) during the reaction, so that one of the above-mentioned

requirements for enabling the polymerization reaction to proceed at a diffusion-limited rate, such that the produced copolymer must not be melted in the reaction mixture but maintains the solid state, can be satisfied.

When a copolymerization reaction is conducted by slurry

- 5 polymerization, a polymerization pressure is generally from 1 to 100 atm, preferably from 3 to 30 atm, and a polymerization temperature is generally from 20 to 115 °C, preferably from 50 to 105 °C. However, the upper limit of the polymerization temperature is a temperature which is highest among temperatures at which the ethylene copolymer produced can maintain
- 10 substantially a powdery state. Such a highest temperature varies depending on the density of the ethylene copolymer produced and the type of a solvent used.

As a solvent to be used for slurry polymerization, the inert solvents, which are mentioned above in connection with the preparation of the solid catalyst system, can be suitably used. Especially, isobutane, isopentane, heptane, hexane and octane are preferred.

As mentioned above, in the present invention, it is important that the ethylene copolymer produced must maintain a powdery state during the polymerization reaction. Therefore, the upper limit of the polymerization temperature is extremely important.

- 20 In the method of the present invention, as mentioned above, ethylene is copolymerized with at least one comonomer. Typical reactors for the polymerization can include slurry loop reactors or autoclaves.

As mentioned above, at least one comonomer to be used in the method of the present invention is selected from the group comprising a compound represented by the formula  $H_2C = CHR$  wherein R is a  $C_1 - C_{20}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or cyclic diene. Illustrative examples of the compounds represented by the

formula  $H_2C = CHR$  include propylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene, 1-eicosene, vinylcyclohexene and styrene.

Illustrative examples of  $C_4 - C_{20}$  linear, branched and cyclic dienes include 1,3-5 butadiene, 1,4-pentadiene, 1,5-hexadiene, 1,4-hexadiene and cyclohexadiene. Of these, propylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene and 1-eicosene are especially preferred.

In producing the ethylene copolymer, the molecular weight of the 10 ethylene copolymer produced can be controlled by changing the content of hydrogen in the reaction system or by changing the polymerization temperature, as described in DE 3127133.2.

In the present invention, the solid catalyst system may contain, in addition to the above-mentioned components, various additives which are 15 known to be useful for the ethylene copolymerization.

The present invention also relates to blend compositions comprising said novel ethylene copolymer and:

- a) a second ethylene copolymer of the present invention of different molecular weight or density; or
- 20 b) a homogeneous narrow composition distribution ethylene/α-olefin interpolymer;
- c) a heterogeneous broad distribution ethylene/α-olefin interpolymer; or
- d) a homopolymer (prepared by a catalyst component other than that used to prepare the ethylene copolymer of the present invention ); or
- 25 e) a combination of any two or more of a), b) c) or d).

When used as the first component (Component I) in all the foregoing blend compositions of the present invention with a second component

(Component II), the ethylene copolymer has the following properties:

The amount of the first ethylene copolymer incorporated into the blended composition of the present invention is from 1 to 99, preferably from 10 to 90, more preferably from 25 to 75, and most preferably from 35 to 65 percent, by weight based on the combined weights of components I and II.

The density of the first ethylene copolymer incorporated into the blended composition of the present invention is generally from generally from 0.870 to 0.980, preferably from 0.890 to 0.965, more preferably from 0.915 to 0.955 g/cm<sup>3</sup>.

10 The melt index ( $I_2$ ) for the first ethylene copolymer incorporated into the blended composition of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably from 0.01 to 3000 g/10 min.

15 The  $I_{21.6}/I_2$  ratio of the first ethylene copolymer incorporated into the blended composition of the present invention is from 15 to 65, preferably from 18 to 55, more preferably is from 20 to 50 or the  $I_{10}/I_2$  ratio is from 5 to 30, preferably from 5 to 28, more preferably is from 5.5 to 25.

20 The  $M_w/M_n$  ratio of the first ethylene copolymer incorporated into the blended composition of the present invention is from 2.5 to 10, preferably from 2.8 to 8, and more preferably from 3 to 7.

Blends compositions comprising the ethylene copolymer with a second ethylene copolymer of the present invention of different molecular weight or density, are another aspect of the present invention. As long as the method of the present invention is essentially applied to the production of an ethylene copolymer, any of a method in which one or more different ethylene copolymers of this invention and each having excellent ESCR properties and different comonomer contents are separately produced using this method and

blended by means of a kneader (hereinafter, frequently referred to as "blending-and-kneading method") and a method in which an ethylene copolymer comprising a mixture of two or more different ethylene copolymer components having different comonomer contents is produced by multi-stage

5 polymerization or using a plurality of different types of catalysts to be used in the present invention, can be very advantageously utilized. Further, an ethylene copolymer comprised of a mixture of two or more different ethylene copolymer components having different comonomer contents can be produced by using a plurality of different types of catalysts to be used in the present invention.. not

10 only can the impact resistance and ESCR properties be further improved. but also a markedly improved balance of various properties, such as impact resistance, rigidity, melt-flow characteristics , can be achieved.

The amount of the second ethylene copolymer of the present invention, incorporated into the blended composition of the present invention is from 1 to 15 99, preferably from 10 to 90, more preferably from 25 to 75, and most preferably from 35 to 65 percent, by weight based on the combined weights of Components I and II.

The density of the second ethylene copolymer incorporated into the blended composition of the present invention is generally from generally from 20 0.915 to 0.985, preferably from 0.935 to 0.983, more preferably from 0.955 to 0.980, and most preferably from 0.960 to 0.978 g/cm<sup>3</sup>.

The melt index ( $I_2$ ) for the second ethylene copolymer incorporated into the blended composition of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably from 0.01 to 3000, 25 most preferably from 10 to 1000 g/10min.

The  $I_{10}/I_2$  ratio of the second ethylene copolymer incorporated into the blended composition of the present invention is from 5 to 30, preferably from

5.3 to 28, more preferably is from 5.5 to 25 or the I<sub>21.6</sub>/I<sub>2</sub> ratio of the second ethylene copolymer incorporated into the blended composition of the present invention is from 15 to 55, preferably from 18 to 55, more preferably is from 20 to 50, most preferably from 22 to 35.

5 The M<sub>w</sub>/M<sub>n</sub> ratio of the second ethylene copolymer incorporated into the blended composition of the present invention is from 2.5 to 10, preferably from 2.8 to 8, and more preferably from 3 to 7.

Blends compositions comprising the ethylene copolymer with homogeneous narrow composition interpolymers, most preferably the 10 substantially linear ethylene/α-olefin interpolymers are another aspect of the present invention. The homogeneous interpolymer components of the blend compositions are herein defined as defined in USP 3,645,992 (Elston), the disclosure of which is incorporated herein by reference. Accordingly, homogeneous interpolymers are those in which the comonomer is randomly 15 distributed within a given interpolymer molecule and wherein substantially all of the interpolymer molecules have the same ethylene/comonomer ratio within that interpolymer. Such interpolymers are distinct from the typical Ziegler catalyzed interpolymers which are known as heterogeneous interpolymers and are those in which the interpolymer molecules do not have the same 20 ethylene/comonomer ratio. The homogeneous polymers are also distinct from LDPE produced by high pressure free radical catalyzed ethylene polymerization which results in highly branched polyethylene which is known to those skilled in the art to have numerous long chain branches.

The term "narrow composition distribution" used herein describes the 25 comonomer distribution for homogeneous interpolymers and means that the homogeneous interpolymers have only a single melting peak as measured by Differential Scanning Calorimetry (DSC) and essentially lack a measurable

"linear" polymer fraction.

The narrow composition distribution homogeneous interpolymers can also be characterized by their SCBDI (Short Chain Branch Distribution Index) or CDBI (Composition Distribution Branch Index) which is defined as the 5 weight percent of the polymer molecules having a comonomer content within 50 percent of the median total molar comonomer content. The CDBI of a polymer is readily calculated from data obtained from techniques known in the art, such as, for example, temperature rising elution fractionation (abbreviated herein as "TREF") as described, for example, in Wild et al, Journal of Polymer 10 Science, Poly. Phys. Ed., Vol. 20, p. 441 (1982), in U.S. Patent 4,798,081 (Hazlitt et al.), or as is described in USP 5,008,204 (Stehling), the disclosure of which is incorporated herein by reference. The technique for calculating CDBI is described in USP 5,322,728 (Davey et al. ) and in USP 5,246,783 (Spenadel et al.) or in U.S. Patent 5,089,321 (Chum et al.) the disclosures of all of which 15 are incorporated herein by reference. The SCBDI or CDBI for the homogeneous narrow composition ethylene/α-olefin interpolymers used in the present invention is preferably greater than 50 percent, especially greater than 70 percent, most preferably greater than 90%.

The narrow composition distribution homogeneous interpolymer blend 20 components of this invention essentially lack a measurable "high density" (or homopolymer) fraction as measured by the TREF technique. The homogeneous interpolymers and polymers have a degree of branching less than or equal to 2 methyls/1000 carbons in 15 percent (by weight) or less, preferably less than 10 percent (by weight), and especially less than 5 percent (by weight).

25 Preferred components of the blends of the current invention are the substantially linear ethylene/α-olefin interpolymers. The substantially linear ethylene/α-olefin interpolymers are herein defined as in US Pat. Nos. 5,272,236

and 5,278,272 by Lai et al (US 5,272,236 and 5,278,272), the teachings of which contained therein, are herein incorporated in their entirety by reference.

The substantially linear ethylene/α-olefin interpolymers are also homogeneous interpolymers as the comonomer is randomly distributed 5 within a given interpolymer molecule and substantially all of the interpolymer molecules have the same ethylene/comonomer ratio within that interpolymer.

However the term "substantially linear" ethylene/α-olefin interpolymer means that the polymer also contains long chain branching. As a result of the 10 constrained geometry of the catalyst, the substantially linear ethylene interpolymers can contain long chain branching, which, as in LDPE, can greatly improve the processability (as measured by the processing index (PI), or onset of melt fracture, or shear thinning capability) compared with other polymers of about the same  $I_2$  and  $M_w/M_n$ . Long chain branching is defined herein as a 15 chain length of at least one carbon more than two carbons less than the total number of carbons in the comonomer. for example, the long chain branch of an ethylene/octene substantially linear ethylene interpolymer is at least seven (7) carbons in length ( that is , 8 carbons less 2 equals 6 carbons plus one equals seven carbons long chain branch length). The long chain branch can be as long 20 as about the same length as the length of the polymer back-bone. Long chain branching is determined by using  $^{13}\text{C}$  nuclear magnetic resonance (NMR) spectroscopy and is quantified using the method of Randall (Rev. Macromol. Chem. Phys., C29 (2&3), p. 285-297), the disclosure of which is incorporated herein by reference. Long chain branching, of course, is to be distinguished 25 from short chain branches which result solely from incorporation of the comonomer, so for example the short chain branch of an ethylene/octene substantially linear polymer is six carbons in length, while the long chain

branch for that same polymer is at least seven carbons in length.

More specifically, the polymer backbone of a substantially linear ethylene/α-olefin interpolymer is substituted with 0.01 long chain branches/1000 carbons to 3 long chain branches/1000 carbons, more preferably 5 from 0.01 long chain branches/1000 carbons to 1 long chain branches/1000 carbons, and especially from 0.05 long chain branches/1000 carbons to 1 long chain branches/1000 carbons.

The substantially linear ethylene/α-olefin interpolymers useful in this invention surprisingly have excellent processability, even though they have 10 relatively narrow molecular weight distributions. The substantially linear ethylene/α-olefin interpolymers have a molecular weight distribution,  $M_w/M_n$ , defined by the equation:

$$M_w/M_n \leq (I_{10}/I_2) - 4.63.$$

Even more surprising, the melt flow ratio ( $I_{10}/I_2$ ) of the substantially 15 linear ethylene/α-olefin interpolymers can be varied essentially independently of the polydispersity index (that is, molecular weight distribution ( $M_w/M_n$ )). This is contrasted with conventional heterogeneously branched linear polyethylene resins having rheological properties such that as the polydispersity index increases, the  $I_{10}/I_2$  value also increases.

20 For the substantially linear ethylene/α-olefin polymers used in the compositions of the invention, the  $I_{10}/I_2$  ratio indicates the degree of long chain branching, that is, the higher the  $I_{10}/I_2$  ratio, the more long chain branching in the polymer.

The "rheological processing index" (PI) is the apparent viscosity (in 25 kpoise) of a polymer measured by a gas extrusion rheometer (GER). The gas extrusion rheometer is described by M. Shida, R.N. Shroff and L.V. Cancio in Polymer Engineering Science, Vol. 17, no. 11, p. 770 (1977), and in

"Rheometers for Molten Plastics" by John Dealy, published by Van Nostrand Reinhold Co. (1982) on page 97-99, both publications of which are incorporated by reference herein in their entirety. All GER experiments are performed at a temperature of 190°C, at nitrogen pressures between 5250 to 500 psig using a 0.0296 inch diameter, 20:1 L/D die with an entrance angle of 180°.

5 For the substantially linear ethylene/α-olefin polymers described herein, the PI is the apparent viscosity (in kpoise) of a material measured by GER at an apparent shear stress of  $2.15 \times 10^6$  dyne/cm<sup>2</sup>. The substantially linear ethylene/α-olefin interpolymers described herein preferably have a PI in the

10 range of 0.01 kpoise to 50 kpoise, preferably 15 kpoise or less. The substantially linear ethylene/α-olefin polymers described herein have a PI less than or equal to 70 percent of the PI of a comparative linear ethylene/α-olefin polymer which does not contain long chain branching but of about the same I<sub>2</sub> and M<sub>w</sub>/M<sub>n</sub>.

15 An apparent shear stress vs. apparent shear rate plot is used to identify the melt fracture phenomena. According to Ramamurthy in Journal of Rheology, 30(2), 337-357, 1986, above a certain critical flow rate, the observed extrudate irregularities may be broadly classified into two main types: surface melt fracture and gross melt fracture.

20 Surface melt fracture occurs under apparently steady flow conditions and ranges in detail from loss of specular gloss to the more severe form of "sharkskin". In this disclosure, the onset of surface melt fracture (OSMF) is characterized at the beginning of losing extrudate gloss at which the surface roughness of extrudate can only be detected by 40X magnification. The critical

25 shear rate at onset of surface melt fracture for the substantially linear ethylene/α-olefin interpolymers is at least 50 percent greater than the critical shear rate at the onset of surface melt fracture of a linear ethylene/α-olefin

polymer which does not contain long chain branching but of about the same  $I_2$  and  $M_w/M_n$ , wherein "about the same" as used herein means that each value is within 10 percent of the comparative value of the comparative linear ethylene polymer.

5 Gross melt fracture occurs at unsteady flow conditions and ranges in detail from regular (alternating rough and smooth, helical, etc.) to random distortions. For commercial acceptability, ( for example , in blown film products), surface defects should be minimal, if not absent. The critical shear rate at onset of surface melt fracture (OSMF) and onset of gross melt fracture  
10 (OGMF) will be used herein based on the changes of surface roughness and configurations of the extrudates extruded by a GER.

The homogeneous interpolymer component of the blend is preferably, an interpolymer of ethylene with at least one comonomer selected from the group comprising compounds represented by the formula  $H_2C = CHR$  wherein R is a  
15  $C_1 - C_{18}$  linear, branched or cyclic alkyl group or a  $C_6 - C_{20}$  aryl group, and a  $C_4 - C_{20}$  linear, branched or cyclic diene. Illustrative examples of the compounds represented by the formula  $H_2C = CHR$  include propylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene, 1-eicosene.  
20 vinylcyclohexene and styrene. Illustrative examples of  $C_4 - C_{20}$  linear, branched and cyclic dienes include 1,3-butadiene, 1,4-pentadiene, 1,5-hexadiene, 1,4-hexadiene and cyclo hexadiene. Of these, propylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene and 1-eicosene are especially  
25 preferred.

The amount of the homogeneous narrow composition distribution ethylene/ $\alpha$ -olefin interpolymer incorporated into the blended composition of

the present invention is from 1 to 99, preferably from 10 to 90, more preferably from 25 to 75, and most preferably from 35 to 65 percent, by weight based on the combined weights of components I and II.

The density of the homogeneous narrow composition distribution 5 ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is generally from 0.915 to 0.985, preferably from 0.935 to 0.983, more preferably from 0.955 to 0.980 g/cm<sup>3</sup>.

The melt index ( $I_2$ ) for the homogeneous narrow composition distribution ethylene/α-olefin interpolymer incorporated into the blended 10 composition of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably from 0.01 to 3000 g/10 min

The  $I_{10}/I_2$  ratio of the homogeneous narrow composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is from 5 to 25, preferably from 5.3 to 25. more 15 preferably is from 5.5 to 20, or the  $I_{21.6}/I_2$  ratio of the homogeneous narrow composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is from 10 to 50, preferably from 12 to 45, more preferably is from 15 to 40.

The  $M_w/M_n$  ratio of the homogeneous narrow composition distribution 20 ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention (including the substantially linear ethylene/α-olefin interpolymer) is less than 3.

The homogeneous narrow composition distribution ethylene/α-olefin interpolymer component may be prepared using the previously described 25 transition metal catalysts. Preparation of the homogeneous narrow composition distribution substantially linear ethylene/α-olefin polymers requires the use of the previously described transition metal compounds and constrained geometry single site catalysts. The activating cocatalysts and activating techniques have been previously taught with respect to different metal complexes in the 30 following references: European Patent EP-A-277,003, US-A-5,153,157, US-A-

5,064,802, European Patents EP-A-468,651 and EP-A-520,732 (equivalent to U. S. Serial No. 07/876,268 filed May 1, 1992), and US-A-5,350,723, the teachings of which are hereby incorporated by reference.

Suitable activating cocatalysts useful in combination with the single site catalyst component are those compounds capable of abstraction of an X substituent therefrom to form an inert, noninterfering counter ion, or that form a zwitterionic derivative of the catalyst component. Suitable activating cocatalysts for use herein include perfluorinated tri(aryl)boron compounds, and most especially tris(pentafluoro-phenyl)borane; nonpolymeric, compatible, noncoordinating, ion forming compounds (including the use of such compounds under oxidizing conditions), especially the use of ammonium-, phosphonium-, oxonium-, carbonium-, silylium- or sulfonium- salts of compatible, noncoordinating anions, and ferrocenium salts of compatible, noncoordinating anions. Suitable activating techniques include the use of bulk electrolysis. A combination of the foregoing activating cocatalysts and techniques may be employed as well.

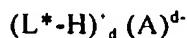
More particularly, suitable ion forming compounds useful as cocatalysts comprise a cation which is a Brønsted acid capable of donating a proton, and a compatible, noncoordinating anion, A<sup>-</sup>. As used herein, the term "noncoordinating" means an anion or substance which either does not coordinate to the Group 4 metal containing precursor complex and the catalytic derivative derived therefrom, or which is only weakly coordinated to such complexes thereby remaining sufficiently labile to be displaced by a neutral Lewis base. "Compatible anions" are anions which are not degraded to neutrality when the initially formed complex decomposes and are noninterfering with desired subsequent polymerization or other uses of the complex.

Preferred anions are those containing a single coordination complex comprising a charge-bearing metal or metalloid core which anion is capable of balancing the charge of the active catalyst species (the metal cation) which may

be formed when the two components are combined. Also, said anion should be sufficiently labile to be displaced by olefinic, diolefinic and acetylenically unsaturated compounds or other neutral Lewis bases such as ethers or nitriles. Suitable metals include, but are not limited to, aluminum, gold and platinum.

5 Suitable metalloids include, but are not limited to, boron, phosphorus, and silicon. Compounds containing anions which comprise coordination complexes containing a single metal or metalloid atom are, of course, well known and many, particularly such compounds containing a single boron atom in the anion portion, are available commercially.

10 Preferably such cocatalysts may be represented by the following general formula:



wherein:

$L^*$  is a neutral Lewis base;

15  $(L^*-H)^d$  is a Bronsted acid;

$A^{d-}$  is a noncoordinating, compatible anion having a charge of  $d-$ , and  $d$  is an integer from 1 to 3.

More preferably  $A^{d-}$  corresponds to the formula:  $[M'Q_4]^{d-}$ ;

wherein:

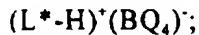
20  $M'$  is boron or aluminum in the +3 formal oxidation state; and

$Q$  independently each occurrence is selected from hydride, dialkylamido, halide, hydrocarbyl, hydrocarbyloxide, halosubstituted-hydrocarbyl, halosubstituted hydrocarbyloxy, and halo- substituted silylhydrocarbyl radicals (including perhalogenated hydrocarbyl- perhalogenated hydrocarbyloxy- and

25 perhalogenated silylhydrocarbyl radicals), said  $Q$  having up to 20 carbons with the proviso that in not more than one occurrence is  $Q$  halide. Examples of suitable hydrocarbyloxide  $Q$  groups are disclosed in U. S. Patent 5,296,433, the teachings of which are herein incorporated by reference.

In a more preferred example,  $d$  is one, that is, the counter ion has a  
30 single negative charge and is  $A^-$ . Activating cocatalysts comprising boron

which are particularly useful in the preparation of catalysts of this invention may be represented by the following general formula:



wherein:

5         $L^*$  is as previously defined;  
B is boron in a formal oxidation state of 3; and  
Q is a hydrocarbyl-, hydrocarbyloxy-, fluorinated hydrocarbyl-,  
fluorinated hydrocarbyloxy-, or fluorinated silylhydrocarbyl- group of up to 20  
nonhydrogen atoms, with the proviso that in not more than one occasion is Q  
10      hydrocarbyl.

Most preferably, Q is each occurrence a fluorinated aryl group,  
especially, a pentafluorophenyl group.

Illustrative, but not limiting, examples of boron compounds which may  
be used as an activating cocatalyst for the present invention are tri-substituted  
15      ammonium salts such as:  
trimethylammonium tetrakis(pentafluorophenyl) borate,  
triethylammonium tetrakis(pentafluorophenyl) borate,  
tripropylammonium tetrakis(pentafluorophenyl) borate,  
tri(n-butyl)ammonium tetrakis(pentafluorophenyl) borate,  
20      tri(sec-butyl)ammonium tetrakis(pentafluorophenyl) borate,  
N,N-dimethyl-N-dodecylammonium tetrakis(pentafluorophenyl) borate,  
N,N-dimethyl-N-octadecylammonium tetrakis(pentafluorophenyl) borate,  
N-methyl-N,N-didodecylammonium tetrakis(pentafluorophenyl) borate,  
N-methyl-N,N-dioctadecylammonium tetrakis(pentafluorophenyl) borate,  
25      N,N-dimethylanilinium tetrakis(pentafluorophenyl) borate,  
N,N-dimethylanilinium n-butyltris(pentafluorophenyl) borate,  
N,N-dimethylanilinium benzyltris(pentafluorophenyl) borate,  
N,N-dimethylanilinium tetrakis(4-(t-butyldimethylsilyl)-2, 3, 5, 6-  
tetrafluorophenyl) borate,  
30      N,N-dimethylanilinium tetrakis(4-(triisopropylsilyl)-2, 3, 5, 6-

tetrafluorophenyl) borate,  
N,N-dimethylanilinium pentafluorophenoxytris(pentafluorophenyl) borate.  
N,N-diethylanilinium tetrakis(pentafluorophenyl) borate,  
N,N-dimethyl-2,4,6-trimethylanilinium tetrakis(pentafluorophenyl) borate,  
5 trimethylammonium tetrakis(2,3,4,6-tetrafluorophenyl)borate,  
triethylammonium tetrakis(2,3,4,6-tetrafluorophenyl) borate,  
tripropylammonium tetrakis(2,3,4,6-tetrafluorophenyl) borate,  
tri(n-butyl)ammonium tetrakis(2,3,4,6-tetrafluorophenyl) borate,  
dimethyl(t-butyl)ammonium tetrakis(2,3,4,6-tetrafluorophenyl) borate,  
10 N,N-dimethylanilinium tetrakis(2,3,4,6-tetrafluorophenyl) borate,  
N,N-diethylanilinium tetrakis(2,3,4,6-tetrafluorophenyl) borate, and  
N,N-dimethyl-2,4,6-trimethylanilinium tetrakis(2,3,4,6-tetrafluorophenyl)  
borate;  
disubstituted ammonium salts such as:  
15 di-(i-propyl)ammonium tetrakis(pentafluorophenyl) borate, and  
dicyclohexylammonium tetrakis(pentafluorophenyl) borate;  
trisubstituted phosphonium salts such as:  
triphenylphosphonium tetrakis(pentafluorophenyl) borate,  
tri(o-tolyl)phosphonium tetrakis(pentafluorophenyl) borate, and  
20 tri(2,6-dimethylphenyl)phosphonium tetrakis(pentafluorophenyl) borate;  
disubstituted oxonium salts such as:  
diphenyloxonium tetrakis(pentafluorophenyl) borate,  
di(o-tolyl)oxonium tetrakis(pentafluorophenyl) borate, and  
di(2,6-dimethylphenyl)oxonium tetrakis(pentafluorophenyl) borate;  
25 disubstituted sulfonium salts such as:  
diphenylsulfonium tetrakis(pentafluorophenyl) borate,  
di(o-tolyl)sulfonium tetrakis(pentafluorophenyl) borate, and  
bis(2,6-dimethylphenyl)sulfonium tetrakis(pentafluorophenyl) borate.  
Preferred (L\*-H)<sup>+</sup> cations are N,N-dimethylanilinium,  
30 tributylammonium, N-methyl-N,N-didodecylammonium, N-methyl-N,N-

dioctadecylammonium, and mixtures thereof.

Another suitable ion forming, activating cocatalyst comprises a salt of a cationic oxidizing agent and a noncoordinating, compatible anion represented by the formula:



wherein  $Ox^{e+}$ ,  $A^{d-}$  and  $d$  are as previously defined.

Examples of cationic oxidizing agents include: ferrocenium, hydrocarbyl-substituted ferrocenium,  $Ag^{+}$  or  $Pb^{2+}$ . Preferred embodiments of  $A^{d-}$  are those anions previously defined with respect to the Bronsted acid 10 containing activating cocatalysts, especially tetrakis(pentafluorophenyl)borate.

Another suitable ion forming, activating cocatalyst comprises a compound which is a salt of a carbenium ion and a noncoordinating, compatible anion represented by the formula:



15 wherein:

$\textcircled{C}^+$  and  $A^-$  are as previously defined. A preferred carbenium ion is the trityl cation, that is triphenylmethylum.

A further suitable ion forming, activating cocatalyst comprises a compound which is a salt of a silylum ion and a noncoordinating, compatible 20 anion represented by the formula:



wherein:

$R^*$  is  $C_{1-10}$  hydrocarbyl, and  $A^-$  are as previously defined.

Preferred silylum salt activating cocatalysts are trimethylsilylum 25 tetrakis(pentafluorophenyl)borate, triethylsilylum tetrakis(pentafluorophenyl)borate and ether substituted adducts thereof. The use of the above silylum salts as activating cocatalysts for addition polymerization catalysts is claimed in USSN 08/304,314, filed September 12, 1994.

Certain complexes of alcohols, mercaptans, silanols, and oximes with 30 tris(pentafluorophenyl)borane are also effective catalyst activators and may be

used for the present invention. Such cocatalysts are disclosed in USP 5,296,433, the teachings of which are herein incorporated by reference.

The most preferred activating cocatalysts are trispentafluorophenylborane and N,Ndioctadecyl-N-methylammonium 5 tetrakis(pentafluorophenyl)borate. The latter compound being the principal component of a mixture of borate salts derived from bis(hydrogenated tallow)methylammonium compounds, which mixture may be used as the activating cocatalyst herein.

The molar ratio of metal complex: activating cocatalyst employed 10 preferably ranges from 1:10 to 2:1, more preferably from 1:5 to 1.5:1, most preferably from 1:5 to 1:1.

Other activators include the previously described aluminoxanes. Preferred aluminoxanes include methylaluminoxane, propylaluminoxane, isobutylaluminoxane. Combinations thereof. So-called modified 15 methylaluminoxane (MMAO) is also suitable for use as a cocatalyst. One technique for preparing such modified alumoxane is disclosed in U.S. Patent No. 4,960,878 (Crapo et al.), the disclosure of which is incorporated herein by reference. Aluminoxanes can also be made as disclosed in U.S. patents Nos. 4,544,762 (Kaminsky et al.); 5,015,749 (Schmidt et al.); 5,041,583 20 (Sangokoya); 5,041,584 (Crapo et al.); and 5,041,585 (Deavenport et al.), the disclosures of all of which are incorporated herein by reference. When aluminoxanes are used as the activating cocatalyst, the molar ratio of transition metal complex: aluminum preferably ranges from 1:2,000 to 2:1, more preferably from 1:1,000 to 1.5:1, most preferably from 1:500 to 1:1. 25 In general, the polymerization may be accomplished at conditions well known in the prior art for Ziegler-Natta or Kaminsky-Sinn type polymerization reactions, that is, temperatures from 0-250 °C, preferably 30 to 200 °C and pressures from atmospheric to 30,000 atmospheres or higher. Suspension, solution, slurry, gas phase, solid state powder polymerization or other process 30 condition may be employed if desired. A solid component (other than that used

to prepare the catalysts used to make the ethylene homopolymer of the present invention), may be employed especially silica, alumina, or a polymer (especially poly(tetrafluoroethylene) or a polyolefin), and desirably is employed when the catalysts are used in a gas phase polymerization process.

5 The support is preferably employed in an amount to provide a weight ratio of catalyst (based on metal):support from 1:100,000 to 1:10, more preferably from 1:50,000 to 1:20, and most preferably from 1:10,000 to 1:30.

In most polymerization reactions the molar ratio of catalyst:polymerizable compounds employed is from  $10^{-12}$ :1 to  $10^1$ :1, more 10 preferably from  $10^{-9}$ :1 to  $10^{-5}$ :1.

Suitable solvents for polymerization are inert liquids. Examples include straight and branched-chain hydrocarbons such as isobutane, butane, pentane, hexane, heptane, octane, and mixtures thereof; cyclic and alicyclic hydrocarbons such as cyclohexane, cycloheptane, methylcyclohexane, 15 methylcycloheptane, and mixtures thereof; perfluorinated hydrocarbons such as perfluorinated C<sub>4-10</sub> alkanes, and aromatic and alkyl-substituted aromatic compounds such as benzene, toluene, xylene, ethylbenzene. Suitable solvents also include liquid olefins which may act as monomers or comonomers including ethylene, propylene, butadiene, cyclopentene, 1-hexene, 1-hexane, 4-20 vinylcyclohexene, vinylcyclohexane, 3-methyl-1-pentene, 4-methyl-1-pentene, 1,4-hexadiene, 1-octene, 1-decene, styrene, divinylbenzene, allylbenzene, vinyltoluene (including all isomers alone or in admixture). Mixtures of the foregoing are also suitable.

Blends compositions comprising the ethylene copolymer with the 25 heterogeneous broad composition distribution ethylene interpolymers are another aspect of the present invention. Included in the definition of heterogeneous interpolymers as used herein are those produced using Ziegler catalysts and also those produced by the chromium-based silica-supported systems, commonly known as the Phillips-type catalysts.

The term heterogeneous describes interpolymers in which the interpolmer molecules do not have the same ethylene/comonomer ratio. The term "broad composition distribution" used herein describes the comonomer distribution for heterogeneous interpolymers and means that the heterogeneous 5 interpolymers have a "linear" fraction and that the heterogeneous interpolymers have multiple melting peaks ( that is , exhibit at least two distinct melting peaks) by DSC. The heterogeneous interpolymers and polymers have a degree of branching less than or equal to 2 methyls/1000 carbons in 10 percent (by weight) or more, preferably more than 15 percent (by weight), and especially 10 more than 20 percent (by weight). The heterogeneous interpolymers also have a degree of branching equal to or greater than 25 methyls/1000 carbons in 25 percent or less (by weight), preferably less than 15 percent (by weight), and especially less than 10 percent (by weight).

The heterogeneous interpolymer component of the blend can also be an 15 ethylene homopolymer or an interpolymer of ethylene with at least one comonomer selected from the group consisting of a compound represented by the formula  $H_2C = CHR$  wherein R is a C<sub>1</sub> - C<sub>18</sub> linear, branched or cyclic alkyl group or a C<sub>6</sub> - C<sub>20</sub> aryl group, and a C<sub>4</sub> - C<sub>20</sub> linear, branched or cyclic diene. Illustrative examples of the compounds represented by the formula H<sub>2</sub>C 20 = CHR include propylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene, 1-eicosene, vinylcyclohexene and styrene. Illustrative examples of C<sub>4</sub> - C<sub>20</sub> linear, branched and cyclic dienes include 1,3-butadiene, 1,4-pentadiene, 1,5-hexadiene, 1,4-hexadiene and cyclo hexadiene. Of these, propylene, 1-butene, 25 1-pentene, 1-hexene, 4-methyl-1-pentene, 1-octene, 1-decene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene and 1-eicosene are especially preferred. Heterogeneous interpolymers of ethylene and 1-butene, 1-pentene,

1-hexene and 1-octene are most preferred.

The amount of the heterogeneous broad composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is from 1 to 99, preferably from 10 to 90, more preferably from 25 to 75, and most preferably from 35 to 65 percent, by weight based on the combined weights of components I and II.

The density of the heterogeneous broad composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is generally from 0.915 to 0.985, preferably from 0.935 to 0.983, more preferably from 0.955 to 0.980 g/cm<sup>3</sup>.

The melt index ( $I_2$ ) for the heterogeneous broad composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably from 0.011 to 3000 g/10 min

The  $I_{10}/I_2$  ratio of the heterogeneous broad composition distribution ethylene/α-olefin interpolymer or homopolymer made by the same catalyst and process conditions as said interpolymer incorporated into the blended composition of the present invention is from 5 to 40, preferably from 5.3 to 35 more preferably from 5.5 to 30, or the  $I_{21.6}/I_2$  ratio of the heterogeneous broad composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is from 15 to 80, preferably from 20 to 70 more preferably from 25 to 60.

The  $M_w/M_n$  ratio of the heterogeneous broad composition distribution ethylene/α-olefin interpolymer incorporated into the blended composition of the present invention is generally from 3 to 12, preferably from 3.5 to 10, more preferably from 4 to 9.

Ziegler-Natta catalysts may be used to prepare the heterogeneous

component of the polymer blend. Preferred Ziegler-Natta catalysts include magnesium alkoxide-based catalysts, such as those taught by USP 4,526,943, USP 4,426,316, 4,661,465, USP 4,783,512, and USP 4,544,647, the disclosures of each of which are herein incorporated by reference. Such catalysts are 5 particularly useful if the heterogeneous polymer component is to be prepared under slurry process conditions.

Additional examples of Ziegler-type catalysts which are particularly useful for preparation of the heterogeneous polymer blend component is to be prepared under the high polymerization temperatures of the solution process, 10 include catalysts derived from organomagnesium compounds, alkyl halides or aluminum halides or hydrogen chloride, and a transition metal compound.

Examples of such catalysts are described in U.S. Pat Nos. 4,314,912 (Lowery, Jr. et al.), 4,547,475 (Glass et al.), and 4,612,300 (Coleman, III), the teachings of which are incorporated herein by reference.

15       Particularly suitable organomagnesium compounds include, for example, hydrocarbon soluble dihydrocarbylmagnesium such as the magnesium dialkyls and the magnesium diaryls. Exemplary suitable magnesium dialkyls include particularly n-butyl-sec-butylmagnesium, diisopropylmagnesium, di-n-hexylmagnesium, isopropyl-n-butyl-magnesium, ethyl-n-hexylmagnesium, 20 ethyl-n-butylmagnesium, di-n-octylmagnesium and others wherein the alkyl has from 1 to 20 carbon atoms. Exemplary suitable magnesium diaryls include diphenylmagnesium, dibenzylmagnesium and ditolylmagnesium. Suitable organomagnesium compounds include alkyl and aryl magnesium alkoxides and aryloxides and aryl and alkyl magnesium halides with the halogen-free 25 organomagnesium compounds being more desirable.

Among the halide sources which can be employed herein are the active non-metallic halides, metallic halides, and hydrogen chloride.

Suitable non-metallic halides are represented by the formula  $R'X$  wherein  $R'$  is hydrogen or an active monovalent organic radical and  $X$  is a halogen. Particularly suitable non-metallic halides include, for example, hydrogen halides and active organic halides such as *t*-alkyl halides, allyl halides, benzyl halides and other active hydrocarbyl halides wherein hydrocarbyl is as defined hereinbefore. By an active organic halide is meant a hydrocarbyl halide that contains a labile halogen at least as active, that is, as easily lost to another compound, as the halogen of *sec*-butyl chloride, preferably as active as *t*-butyl chloride. In addition to the organic monohalides, it is understood that organic dihalides, trihalides and other polyhalides that are active as defined herein before are also suitably employed. Examples of preferred active non-metallic halides include hydrogen chloride, hydrogen bromide, *t*-butyl chloride, *t*-amyl bromide, allyl chloride, benzyl chloride, crotyl chloride, methylvinyl carbinyl chloride, *a*-phenylethyl bromide, diphenyl methyl chloride. Most preferred are hydrogen chloride, *t*-butyl chloride, allyl chloride and benzyl chloride.

Suitable metallic halides which can be employed herein include those represented by the formula  $MR_y-aX_a$  wherein:

$M$  is a metal of Groups IIB, IIIA or IVA of Mendeleev's Periodic Table  
20 of Elements,

$R$  is a monovalent organic radical,

$X$  is a halogen,

$Y$  has a value corresponding to the valence of  $M$ , and  $a$  has a value from 1 to  $y$ .

25 Preferred metallic halides are aluminum halides of the formula  $AlR_3-aX_a$  wherein:

each  $R$  is independently hydrocarbyl as hereinbefore defined such

as alkyl,

X is a halogen; and

a is a number from 1 to 3.

Most preferred are alkylaluminum halides such as ethylaluminum sesquichloride, diethylaluminum chloride, ethylaluminum dichloride, and diethylaluminum bromide, with ethylaluminum dichloride being especially preferred. Alternatively, a metal halide such as aluminum trichloride or a combination of aluminum trichloride with an alkyl aluminum halide or a trialkyl aluminum compound may be suitably employed.

10 It is understood that the organic moieties of the aforementioned organomagnesium, for example, R", and the organic moieties of the halide source, for example, R and R', are suitably any other organic radical provided that they do not contain functional groups that poison conventional Ziegler catalysts.

15 The magnesium halide can be preformed from the organomagnesium compound and the halide source or it can be formed in situ in which instance the catalyst is preferably prepared by mixing in a suitable solvent or reaction medium (1) the organomagnesium component and (2) the halide source, followed by the other catalyst components.

20 Any of the conventional Ziegler-Natta transition metal compounds can be usefully employed as the transition metal component in preparing the supported catalyst component. Typically, the transition metal component is a compound of a Group IVB, VB, or VIB metal. The transition metal component is generally, represented by the formulas:  $TrX'^{4-q}(OR^1)_q$ ,  $TrX'^{4-q}R^2_q$ ,  $VOX'^3$  and  $VO(OR^1)_3$ .

Tr is a Group IVB, VB, or VIB metal, preferably a Group IVB or VB metal, preferably titanium, vanadium or zirconium,

q is 0 or a number equal to or less than 4.

X' is a halogen, and

R<sup>1</sup> is an alkyl group, aryl group or cycloalkyl group having from 1 to 20 carbon atoms, and

5 R<sup>2</sup> is an alkyl group, aryl group, aralkyl group, substituted aralkyls, . The aryl, aralkyls and substituted aralkyls contain 1 to 20 carbon atoms, preferably 1 to 10 carbon atoms. When the transition metal compound contains a hydrocarbyl group, R<sup>2</sup>, being an alkyl, cycloalkyl, aryl, or aralkyl group, the hydrocarbyl group will preferably not contain an H atom in the position beta to  
10 the metal carbon bond. Illustrative but non-limiting examples of aralkyl groups are methyl, neo-pentyl, 2,2-dimethylbutyl, 2,2-dimethylhexyl; aryl groups such as benzyl; cycloalkyl groups such as 1-norbornyl. Mixtures of these transition metal compounds can be employed if desired.

Illustrative examples of the transition metal compounds include TiCl<sub>4</sub>,  
15 TiBr<sub>4</sub>, Ti(OC<sub>2</sub>H<sub>5</sub>)<sub>3</sub>Cl, Ti(OC<sub>2</sub>H<sub>5</sub>)Cl<sub>3</sub>, Ti(OC<sub>4</sub>H<sub>9</sub>)<sub>3</sub>Cl, Ti(OC<sub>3</sub>H<sub>7</sub>)<sub>2</sub>Cl<sub>2</sub>,  
Ti(OC<sub>6</sub>H<sub>13</sub>)<sub>2</sub>Cl<sub>2</sub>, Ti(OC<sub>8</sub>H<sub>17</sub>)<sub>2</sub>Br<sub>2</sub>, and Ti(OC<sub>12</sub>H<sub>25</sub>)Cl<sub>3</sub>, Ti(O-i-C<sub>3</sub>H<sub>7</sub>)<sub>4</sub>, and  
Ti(O-n-C<sub>4</sub>H<sub>9</sub>)<sub>4</sub>.

Illustrative examples of vanadium compounds include VCl<sub>4</sub>, VOCl<sub>3</sub>,  
VO(OC<sub>2</sub>H<sub>5</sub>)<sub>3</sub>, and VO (OC<sub>4</sub>H<sub>9</sub>)<sub>3</sub>.

20 Illustrative examples of zirconium compounds include ZrCl<sub>4</sub>,  
ZrCl<sub>3</sub>(OC<sub>2</sub>H<sub>5</sub>), ZrCl<sub>2</sub>(OC<sub>2</sub>H<sub>5</sub>)<sub>2</sub>, ZrCl(OC<sub>2</sub>H<sub>5</sub>)<sub>3</sub>, Zr(OC<sub>2</sub>H<sub>5</sub>)<sub>4</sub>, ZrCl<sub>3</sub>(OC<sub>4</sub>H<sub>9</sub>),  
ZrCl<sub>2</sub>(OC<sub>4</sub>H<sub>9</sub>)<sub>2</sub>, and ZrCl(OC<sub>4</sub>H<sub>9</sub>)<sub>3</sub>.

As indicated above, mixtures of the transition metal compounds may be usefully employed, no restriction being imposed on the number of transition  
25 metal compounds which may be contracted with the support. Any halogenide and alkoxide transition metal compound or mixtures thereof can be usefully employed. The previously named transition metal compounds are especially

preferred with vanadium tetrachloride, vanadium oxychloride, titanium tetraisopropoxide, titanium tetrabutoxide, and titanium tetrachloride being most preferred.

Suitable Ziegler catalyst materials may also be derived from a inert 5 oxide supports and transition metal compounds. Examples of such compositions suitable for use in the solution polymerization process are described in U.S. Pat No. 5,420,090 (Spencer, et al.), the teachings of which are incorporated herein by reference.

The amount of the homopolymer prepared with a catalyst other than that 10 used to prepare the ethylene copolymer of the present invention incorporated into the blended composition of the present invention is from 1 to 99, preferably from 10 to 90, more preferably from 25 to 75, and most preferably from 35 to 65 percent, by weight based on the combined weights of components I and II.

15 The melt index ( $I_2$ ) for the homopolymer prepared with a catalyst and process other than that used to prepare the ethylene copolymer of the present invention incorporated into the blended composition of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, more preferably from 0.01 to 3000 g/10 min

20 The  $I_{21.6}/I_2$  ratio of the homopolymer prepared with a catalyst and process other than that used to prepare the ethylene copolymer of the present invention incorporated into the blended composition of the present invention is from 15 to 80, preferably from 18 to 70 more preferably from 20 to 60 or the  $I_{10}/I_2$  is from 5 to 40, preferably from 5.3 to 35 more preferably from 5.5 25 to 30

The  $M_w/M_n$  ratio of the homopolymer prepared with a catalyst and process other than that used to prepare the ethylene copolymer of the present

invention incorporated into the blended composition of the present invention is generally from 2.5 to 12, preferably from 2.8 to 10, more preferably from 3 to 9.

If blends of the ethylene copolymer of the present invention as described 5 herein, are required with further ethylene interpolymers, each component can be made separately in different reactors, and subsequently blended together.

The blend compositions may also be produced via a continuous (as opposed to a batch or semi-batch operation) controlled polymerization process using at least one reactor. Preferably, though, the ethylene copolymer of the 10 present invention and the additional ethylene interpolymers components of the blend compositions are made in a multiple reactor scheme, operated either in parallel or in series, such as those disclosed in USP 3,914,342 (Mitchell) and WO 94/00500, the teachings of which are hereby incorporated herein by reference. For example, at least two reactors operated in series, that is, one 15 after the other, may be used. Alternatively, the reactors may be operated in parallel, that is, conducting the polymerization steps A and B in separate reactors and subsequently combining melt streams to yield a composite product blend. In the multiple reactor scheme, at least one of the reactors makes the ethylene copolymer of the present invention using the supported metallocene 20 catalyst described herein, under slurry process conditions, and at least one of the reactors makes the additional components of the blend using the required single or multiple catalysts at polymerization temperatures, pressures and feed concentrations required to produce the polymer with the desired properties

Thus in one embodiment, the ethylene copolymer of the present 25 invention using the supported metallocene catalyst described herein, is made under slurry process conditions in a first reactor in Step A and the contents of the first reactor passed to a second reactor in which the feed concentrations and

the temperature are adjusted, to form under slurry process conditions in Step B a second ethylene copolymer of the present invention having a different molecular weight or density.

In a further embodiment, the ethylene copolymer of the present invention 5 using the supported metallocene catalyst described herein, is made under slurry process conditions in a first reactor in Step A and the contents of the first reactor passed to a second reactor in which the feed concentrations and the temperature are adjusted, and one or more of the Ziegler catalysts described herein added, to form, in Step B, under slurry process conditions, the 10 heterogeneous ethylene interpolymer or homopolymer component of the polymer blend with the desired properties.

In a further embodiment the ethylene copolymer of the present invention using the supported metallocene catalyst described herein, is made under slurry process conditions in a first reactor in Step A and the contents of the first 15 reactor enter a second reactor in which the feed concentrations and temperatures are adjusted and one of the metallocene catalysts described herein is added to form the homogeneous ethylene interpolymer or homopolymer component of the polymer blend with the desired properties in Step B under solution process conditions.

20 In a further embodiment, the ethylene copolymer of the present invention using the supported metallocene catalyst described herein, is made under slurry process conditions in a first reactor in Step A and the contents of the first reactor passed to a second reactor in which the temperature and feed concentrations are adjusted, and one or more of the Ziegler catalysts described 25 herein added, to form, in Step B, under solution process conditions, the heterogeneous ethylene interpolymer or homopolymer component of the polymer blend with the desired properties.

Additives such as antioxidants ( for example , hindered phenolics ( for example , Irganox™ 1010), phosphites ( for example , Irgafos™ 168)), cling additives ( for example , PIB), antiblock additives, pigments, fillers, can also be included in the formulations, to the extent that they do not interfere with the 5 enhanced formulation properties discovered by Applicants. Both Irganox™ and Irgafos™ are made by and trademarks of Ciba Geigy Corporation. Irgafos™ 168 is a phosphite stabilizer and Irganox™ 1010 is a hindered polyphenol stabilizer ( for example , tetrakis [methylene 3-(3,5-di *t*-butyl-4-hydroxyphenylpropionate)]-methane.

10 The density of the final blend compositions of the present invention is generally from generally from 0.870 to 0.980, preferably from 0.915 to 0.975, more preferably from 0.935 to 0.970, and most preferably from 0.945 to 0.968 g/cm<sup>3</sup>.

15 The melt index,  $I_2$ , of the final blend compositions of the present invention is generally from 0.0001 to 10000, preferably from 0.001 to 5000, and more preferably from 0.01 to 3000 g/10 min.

16 The  $I_{10}/I_2$  ratio of the final blend compositions of the present invention is from 5 to 100, preferably from 5 to 90 more preferably from 5 to 80, or the  $I_{21.6}/I_2$  ratio of the final blend compositions of the present invention is 20 from 20 to 200, preferably from 30 to 180, more preferably from 40 to 150, and most preferably from 50 to 130.

25 The  $M_w/M_n$  ratio of the final blend compositions of the present invention is from 2.5 to 50, preferably from 3 to 45, and more preferably from 5 to 40.

26 The ethylene copolymer of the present invention has a specific comonomer content distribution characteristic, wherein, in one aspect, the lower the molecular weight of a copolymer fraction in a molecular weight

distribution of an ethylene copolymer, the lower the comonomer content of the copolymer fraction; and, in the other aspect, the higher the molecular weight of a copolymer fraction, the higher the comonomer content of the copolymer fraction. By virtue of this comonomer content distribution characteristic, the 5 ethylene copolymer of the present invention has excellent properties, such as high impact strength and excellent environmental stress cracking resistance (ESCR). Further, the ethylene copolymer of the present invention does not exhibit a broad tailing on both the low molecular weight side and the high molecular weight side, so that the ethylene copolymer contains substantially no 10 impurities such as a wax, a gel. Further, as long as the method of the present invention is essentially applied to the production of an ethylene copolymer, any of a method in which two or more different ethylene copolymers having different comonomer contents are separately produced and blended by means of a kneader, and a method in which an ethylene copolymer comprising a mixture 15 of two or more different ethylene copolymer components having different comonomer contents is produced by multi-stage polymerization or using a plurality of different types of catalysts to be used in the present invention, can be very advantageously utilized in a preferred mode of the method of the present invention. The mixture of the ethylene copolymers produced by the 20 above-mentioned preferred method of the present invention can have a comonomer content distribution in which the comonomer content continuously varies in accordance with an increase in molecular weight of the copolymer, contrary to that of the mixture of conventional ethylene copolymers. Thus, according to the above-mentioned slurry method of the present invention, 25 excellent characteristic can be obtained with respect to the comonomer content distribution of the mixture of the ethylene copolymers, which has not been achieved by the prior art techniques.

Due to the above-mentioned excellent properties and characteristics, the ethylene copolymer and blend compositions of the present invention can be advantageously used for the production of blown films, cast films, laminate films, blow-molded articles, injection-molded articles, pipes, coating materials 5 for electric transmission cables.

## EXAMPLES

The present invention will now be further illustrated in more detail with reference to the following Examples and Comparative Examples, which should 10 not be construed as limiting the scope of the present invention.

### Example 1

20 g of silica SP-9-10046 (manufactured and sold by Grace GmbH. Germany), which had been treated at 250°C for 2 hours under vacuum, was slurried in 250 ml of toluene. To the resultant slurry was added a solution of 20 15 ml (0.11 mol) of triethylaluminum in 100 ml of toluene. The resultant mixture was stirred for 2 hours, filtered, washed with two 100 ml portions of fresh toluene and dried under vacuum. The resultant 22g of dried mixture was slurried in 300 ml of toluene and heated to 70°C to thereby obtain a slurry. To this slurry was added a solution of 1.25 g (1.77 mmol) of triethylammonium 20 tris(pentafluorophenyl)(4-hydroxyphenyl)borate in 200 ml of toluene which had been heated to and maintained at 70°C for 30 minutes. Upon addition the heating was removed and the resultant mixture was stirred for 3 hours. After that, a 12.3 ml aliquot of a dark violet colored 0.0714M solution of titanium (N-1,1-dimethylethyl)dimethyl[1-(1,2,3,4,5,-eta)-2,3,4,5-tetramethyl-2,4- 25 cyclopentadien-1-yl]silanaminato[(2-)N]-(η<sup>4</sup> -1,3-pentadiene) in ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA) was added to the mixture and the resultant mixture was stirred for 2 hours to thereby obtain a

green colored solid catalyst system.

Isopentane, ethylene, 1-butene, hydrogen and the solid catalyst system were continuously fed to a 10-liter jacketed, continuously stirred tank reactor.

The flow rates of isopentane, ethylene, 1-butene and hydrogen were,

5 respectively, 2,500 g/hr, 700 g/hr, 20 g/hr and 0.3 liter/hr. The slurry product formed was continuously withdrawn from the reactor. The total pressure of the reactor was 15 atm and the internal temperature of the reactor was maintained at 70 °C. The slurry withdrawn was fed to a flash tank to remove the diluent and the dry, free flowing ethylene copolymer powder was obtained.

10 The ethylene copolymer thus obtained had the following properties: a density by ASTM D-792 of 0.929 g/cm<sup>3</sup>; a melt index of 0.50 g/10 minutes as measured by ASTM D-1238 at 190°C under a load of 2.16 kg; an M<sub>w</sub> of 152,000 and an M<sub>w</sub>/M<sub>n</sub> of 4.5, both as measured by GPC; an M<sub>t</sub> (a point in molecular weight on a molecular weight distribution profile as measured by 15 GPC at which the profile showed a peak having a maximum intensity) of 69,000; an approximate straight line obtained from the comonomer content distribution profile) had a gradient of 0.0013 within the range of from 22,000 to 220,000 in terms of a molecular weight M<sub>c</sub> which satisfies the formula log 20 (69,000)-log(M<sub>c</sub>) ≤ 0.5; a temperature (at which a maximum amount of extraction was exhibited) of 86°C as measured by CFC; in CFC an approximate straight line having a gradient of -0.053 was obtained from the relationship between an arbitrary temperature falling within the range of between 86°C and 96°C and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature, which point had a peak having a 25 maximum intensity; and the total amount of copolymer fractions extracted at temperatures of 76°C or less in CFC was 3.1 wt%.

Examples 2 and 3

25 g of silica SP-9-10046 (manufactured and sold by Grace GmbH, Germany) having a water content of 3.5 % by weight was added to 508 g of 10 % methylalumoxane solution in toluene (manufactured and sold by Witco GmbH, Germany) while continuously stirring. The mixture was stirred for a further two hours and then the solvent was removed under reduced pressure at 20 °C to yield a free-flowing powder. The resulted free-flowing powder was then heated at 175 °C for two hours under vacuum. The resulting powder was re-slurried in 700 ml of toluene and the mixture was washed with two portions of fresh toluene at 100 °C. The support was then dried under vacuum at 120 °C for 1 hour. 63.9 g of support was obtained having an aluminum content of 26.4% by weight.

To 60 gram of the support was added a 33.6 ml aliquot of a dark violet 0.0714 M solution of titanium (N-1,1-dimethylethyl)dimethyl[1-(1,2,3,4,5-eta)-15 2,3,4,5-tetramethyl-2,4-cyclopentadien-1-yl]silanaminato[(2-)N]-(eta 4-1,3-pentadiene) in ISOPAR<sup>TM</sup> E (manufactured and sold by EXXON Chemical Co., USA) and the mixture stirred for several hours to yield a green colored supported catalyst.

Substantially the same polymerization procedures as in Example 1 were 20 repeated, except that the flow rates of isopentane, ethylene, 1-butene and hydrogen were changed as indicated in Table 1. The results of the reactions are shown in Table 1.

Examples 4 to 6

Substantially the same procedures were used as in Examples 2 and 3 to 25 produce the supported catalyst, except that a different MAO treated silica was used wherein the MAO was also immobilized on the silica, but using a different method.

Substantially the same polymerization procedures as in Example 1 were used, except that the polymerization temperatures and the flow rates of isopentane, 1-butene and hydrogen were changed as indicated in Table 1. The gradient and CFC 1 and CFC 2 data for Examples 4-6 are extrapolates, based on density, from the results of Example 1-3.

5 The results of the reactions are shown in Table 1.

Examples 7

6.2 g (8.8 mmol) of triethylammonium tris(pentafluorophenyl)(4-hydroxyphenyl)borate was dissolved in 4 liter of toluene which had been heated 10 to and maintained at 90°C for 30 minutes. To this solvent was added a 40ml aliquot of a 1M solution of trihexylaluminum in toluene. The resultant mixture was stirred for 1 min at 90°C. In a second vessel, 100g of silica P-10 (manufactured and sold by Fuji silysia, Japan), which had been treated at 500°C for 3 hours in flowing nitrogen, was slurried in 1.7 liter of toluene. This silica 15 slurry was heated to 90°C. To this silica slurry was added said mixture of triethylammonium tris(pentafluorophenyl)(4-hydroxyphenyl)borate and triethylaluminum which was at 90°C, and the resulting slurry stirred for 3 hours at 90°C. A 206 ml aliquot of a 1 M solution of trihexylaluminum in toluene was added. The resultant mixture in about 5.9 liter of toluene was stirred at 90°C for 20 1 hour. Then the supernatant of the resultant mixture was removed by decantation method using 90°C toluene to remove excess trihexylaluminum. The decantation was repeated 5 times. After that, a 20 ml aliquot of a dark violet colored 0.218M solution of titanium (N-1,1-dimethylethyl)dimethyl[1-(1,2,3,4,5,-eta)-2,3,4,5-tetramethyl-2,4-cyclopentadien-1-yl]silanaminato[(2- 25 )N]-( $\eta^4$  -1,3-pentadiene) in ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA) was added to the mixture and the resultant mixture was stirred for 3 hours to thereby obtain a green colored solid catalyst system.

Hexane, ethylene, 1-butene, hydrogen and the solid catalyst system were continuously fed to a continuously stirred tank reactor. The flow rates of hexane, ethylene, and hydrogen were, respectively, 46.2 kg/hr, 0.15 kg/hr, 0.15 kg/hr. The flow rates of 1-butene were 0.11 kg/hr (Example 7). The slurry 5 product formed was continuously withdrawn from the reactor. The total pressure of the reactor was 10 atm and the internal temperature of the reactor was maintained at 80 °C. The slurry withdrawn was fed to a flash tank to remove the diluent and the dry, free flowing ethylene copolymer powder was obtained. The properties of the ethylene copolymers thus obtained are shown in 10 Table 2.

Examples 8

200g of silica P-10 (manufactured and sold by Fuji silysia, Japan), which had been treated at 500°C for 3 hours in flowing nitrogen, was slurried in 5 liter of hexane. To the resultant slurry was added a 400 ml aliquot of a 1 M solution 15 of triethylaluminum in hexane. The resultant mixture was stirred for 0.5 hour at room temperature. To this slurry was added a solution of 20.1g (17.6 mmol) of bis(hydrogenated tallowalkyl)methylammonium tris(pentafluorophenyl)(4-hydroxyphenyl)borate in 296 ml of toluene. The resultant mixture was stirred for 0.5 hour at room temperature. After that, a 60 ml aliquot of a dark violet 20 colored 0.218M solution of titanium (N-1,1-dimethylethyl)dimethyl[1-(1,2,3,4,5,-eta)-2,3,4,5-tetramethyl-2,4-cyclopentadien-1-yl]silanaminato[(2-) $\eta$ ]-( $\eta$ <sup>4</sup> -1,3-pentadiene) in ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA) was added to the mixture and the resultant mixture was stirred for 3 hours at room temperature to thereby obtain a green colored solid 25 catalyst system.

Substantially the same polymerization procedures as in Example 7 were repeated, except that the flow of 1-butene was changed as indicated in Table 1.

The results of the reactions are shown in Table 2.

Comparative Example 1

A 1,000 ml flask was charged with 508 g of a 10 % solution of methylaluminoxane in toluene (manufactured and sold by Witco GmbH, 5 Germany) and then 25 g of silica SD 3216.30 silica (manufactured and sold by Grace GmbH, Germany) having a water content of about 3.5 % by weight was added to the flask while continuously stirring. The resultant mixture was stirred for a further 2 hours and then the solvent was removed under reduced pressure at 20 °C to thereby obtain a free flowing powder. The obtained powder was 10 then heated at 175 °C for 2 hours under vacuum. The powder was re-slurried in 700 ml of toluene. The resultant mixture was heated and refluxed for 1 hour. The mixture was filtered, washed with two portions of fresh toluene at 100 °C and dried under vacuum at 120 °C for 1 hour. As a result, 63.9 g of dried 15 mixture having an aluminum content of 23.8 % by weight was obtained.

A solid catalyst system was prepared by slurring 0.5 g of the above-obtained dried mixture in 20 ml of ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA), and after stirring for a few minutes to disperse the dried mixture, a 0.142 ml aliquot of a dark orange-brown colored solution of [(tert-butylamido)(dimethyl)(tetramethyl- $\eta^5$ -cyclopentadienyl)silane 20 dimethyltinanium was added. The resultant mixture was stirred for a few minutes to thereby obtain a yellow-orange colored solid catalyst system.

A stirred 3-liter reactor was charged with 1,191ml of ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA), 309 ml of 1-octene and 0.3 liter of hydrogen. The reactor contents were heated to 80 °C and ethylene 25 was added to the reactor in an amount sufficient to bring the total pressure of the reactor to about 31 atm. The solid catalyst system containing 1.5  $\mu$ mol of titanium was added to the reactor to thereby initiate a polymerization reaction.

Ethylene was supplied to the reactor continuously on demand. After 21 minutes the ethylene line was blocked and the reactor contents were dumped into a sample container. The resultant copolymer was dried overnight. As a result, 41 g of an ethylene copolymer was obtained.

5        The ethylene copolymer thus obtained had the following properties: a density of 0.883 g/cm<sup>3</sup>; an MFR of 0.35 g/10 minutes as measured at 190°C under a load of 2.16 kg; an M<sub>w</sub> of 130,000 and an M<sub>w</sub>/M<sub>n</sub> of 3.5, both as measured by GPC; an M<sub>t</sub> (a point in molecular weight on a molecular weight distribution profile as measured by GPC at which the profile showed a peak

10      having a maximum intensity) of 96,000; an approximate straight line obtained from the comonomer content distribution profile) had a gradient of 0.0030 within the range of from 30,000 to 304,000 in terms of a molecular weight M<sub>c</sub> which satisfies the formula  $\log(96,000) - \log(M_c) \leq 0.5$ ; a temperature (at which a maximum amount of extraction was exhibited) of 37 °C as measured by CFC;

15      in CFC an approximate straight line having a gradient of -0.010 was obtained from the relationship between an arbitrary temperature falling within the range of between 37 °C and 47 °C and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature, which point had a peak having a maximum intensity; and the total amount of

20      copolymer fractions extracted at temperatures of 27 °C or less in CFC was 18.5 wt%.

#### Comparative Example 2

A 200-ml glass flask, which had been fully purged with nitrogen gas, was charged with 4.0 g of silica (manufactured and sold by Fuji Silysia

25      Chemical Ltd., Japan) and 40 ml of toluene. The resultant mixture was stirred to obtain a suspension. The obtained suspension was cooled to -10 °C. To the cooled suspension was dropwise added 30 ml of a solution of

methylaluminoxane (manufactured and sold by Albemarle Corporation, USA) in toluene (Al concentration: 1 mol/liter) over 1 hour in a nitrogen atmosphere, while maintaining the temperature of the suspension at -10 °C. The resultant mixture was maintained at 0°C for 1 hour and then at room temperature for 1 5 hour, in the nitrogen atmosphere. Thereafter, the temperature of the mixture was further elevated to 110 °C, so that the mixture was refluxed for 3 hours, in the nitrogen atmosphere. During a series of the above operations, generation of methane gas from the mixture was observed. Then, the mixture was cooled to 20 °C, so that a suspension of a silica having methylaluminoxane carried 10 thereon was obtained.

A 1.6-liter stainless autoclave, which had been fully purged with nitrogen gas, was charged with 0.8 liter of hexane and then 0.2 mmol of triisobutylaluminum was added to the hexane in the autoclave. To the resultant mixture was added the above-obtained silica suspension in an amount of 0.3 15 mmol in terms of the aluminum of the methylaluminoxane carried on the silica. Ethylene was added to the autoclave in an amount sufficient to bring the total pressure of the autoclave to 7kg/cm<sup>2</sup>-G. The internal temperature of the autoclave was adjusted to 65 °C.

A solution of bis(n-butylcyclopentadienyl)zirconium dichloride (which 20 is known as a metallocene) in toluene was added to the autoclave in an amount of 1.0μmol in terms of zirconium, and the internal temperature of the autoclave was elevated to 70 °C, to thereby initiate a polymerization reaction of the ethylene. The ethylene was supplied to the autoclave continuously on demand.

While maintaining the total pressure of the autoclave at 7 kg/cm<sup>2</sup>-G and 25 maintaining the internal temperature of the autoclave at 70 °C, the polymerization reaction was carried out, so that the total consumption of ethylene became 1.5 kg/cm<sup>2</sup>-G.

After completion of the polymerization reaction, the contents in the autoclave were dumped into a stainless container containing methanol. The resultant mixture was filtered to thereby obtain a polymer. The obtained polymer was dried at 50°C overnight. As a result, an ethylene copolymer was 5 obtained.

The autoclave was opened and the inside thereof was examined. No polymer adhering to the inner wall of the autoclave was observed.

The ethylene copolymer thus obtained had the following properties: a density of 0.926 g/cm<sup>3</sup>; an MFR of 2.1 g/10 minutes as measured at 190°C 10 under a load of 2.16 kg; an M<sub>w</sub> of 88,000 and an M<sub>w</sub>/M<sub>n</sub> of 2.6, both as measured by GPC; an M<sub>t</sub> (a point in molecular weight on a molecular weight distribution profile as measured by GPC at which the profile showed a peak having a maximum intensity) of 63,000; an approximate straight line obtained from the comonomer content distribution profile) had a gradient of -0.00005 15 within the range of from 20,000 to 199,000 in terms of a molecular weight M<sub>c</sub> which satisfies the formula  $\log(63,000) - \log(M_c) \leq 0.5$ ; a temperature (at which a maximum amount of extraction was exhibited) of 85 °C as measured by CFC; in CFC an approximate straight line having a gradient of -0.006 was obtained 20 from the relationship between an arbitrary temperature falling within the range of between 85 °C and 95 °C and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature, which point had a peak having a maximum intensity; and the total amount of copolymer fractions extracted at temperatures of 75°C or less in CFC was 10.8 wt%.

25 Comparative Example 3

A stirred 3-liter reactor was charged with 1,388 ml of ISOPAR™ E (manufactured and sold by Exxon Chemical Co., USA), 128 ml of 1-octene and

0.3 liter of hydrogen. The reactor contents were heated to 130 °C and ethylene was added to the reactor in an amount sufficient to bring the total pressure of the reactor to about 31 atm.

A solid catalyst system containing 0.625  $\mu$ mol of titanium, which was 5 prepared in substantially the same manner as in Example 1, was added to the reactor to thereby initiate a polymerization reaction. Ethylene was supplied to the reactor continuously on demand. After 10 minutes the ethylene line was blocked and the reactor contents were dumped into a sample container. The resultant polymer was dried overnight, to thereby obtain 30 g of an ethylene 10 copolymer.

The ethylene copolymer thus obtained had the following properties: a density of 0.912 g/cm<sup>3</sup>; an MFR of 4.5 g/10 minutes as measured at 190 °C under a load of 2.16 kg; an M<sub>w</sub> of 130,000 and an M<sub>w</sub>/M<sub>n</sub> of 2.5, both as measured by GPC; an M<sub>t</sub> (a point in molecular weight on a molecular weight 15 distribution profile as measured by GPC at which the profile showed a peak having a maximum intensity) of 50,000; an approximate straight line obtained from the comonomer content distribution profile) had a gradient of 0.00003 within the range of from 16,000 to 158,000 in terms of a molecular weight M<sub>c</sub> which satisfies the formula  $\log(50,000) - \log(M_c) \leq 0.5$ ; a temperature (at which 20 a maximum amount of extraction was exhibited) of 74 °C as measured by CFC; in CFC an approximate straight line having a gradient of -0.033 was obtained from the relationship between an arbitrary temperature falling within the range of between 74 °C and 84 °C and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature, which 25 point had a peak having a maximum intensity; and the total amount of copolymer fractions extracted at temperatures of 64 °C or less in CFC was 13.4 wt%.

Comparative Example 4

A commercially available ethylene copolymer, EXACT<sup>TM</sup> 3029 (manufactured and sold by Exxon Chemical Co., USA), was analyzed. The results of the analysis are shown in Table 2.

5 Comparative Example 5

A commercially available ethylene copolymer, SP 2040 (manufactured and sold by Mitsui Petrochemical Industries, Ltd., Japan), was analyzed. The results of the analysis are shown in Table 2.

Comparative Example 6

10 A commercially available ethylene copolymer, PL 1880 (manufactured and sold by The Dow Chemical Co., USA), was analyzed. The results of the analysis are shown in Table 2.

In Table 2, the properties of the ethylene copolymer of the present invention, which was obtained in Example 1, are indicated together with those 15 of the ethylene copolymers which were individually obtained in Comparative Examples 1 to 3 and those of the commercially available ethylene copolymers in Comparative Examples 4 to 6. It is apparent that any of the ethylene copolymers in Comparative Examples 1 to 6 do not have the properties which match those of the ethylene copolymer of the present invention.

20 Comparative Example 7

A magnesium-chloride supported Ziegler-Natta catalysts having about 2 wt% of Ti on the surface of the support was used for the polymerization.

Hexane, ethylene, 1-butene, hydrogen and the solid catalyst system were continuously fed to a continuously stirred tank reactor substantially as 25 described in Example 1 to produce the copolymer powder, the properties of which are shown in Table 2.

Examples 9-12.

Substantially the same polymerization procedures as in Example 1 were used, except that the transition metal complex used to prepare components 1 and 2 was [(tert-butylamido)(dimethyl)(tetramethyl- $\eta^5$ -cyclopentadienyl)dimethyltitanium and the flow rates of isopentane, 1-butene and hydrogen were changed to produce the polymer properties for Components I and II summarized in Table 3. The blends were prepared in a Winkworth 2Z-blade mixer. This internal mixer is equipped with two mixing blades running at different rpm: the front screw rotates at 52 rpm, the rear screw at 30 rpm. The working capacity is 1.2 liters.

The powders were first dry blended with 2000 ppm Irganox<sup>®</sup> B225 available from Ciba Geigy. Charges of 350 g of the mixture of the desired composition were then loaded and mixed for 10 minutes at 190°C. After mixing the polymer was removed and was milled in a Heinrich Dreher S20 grinder. The ground polymer was then ready for compression molding. The results of the testing of the various blend compositions are shown in Table 4.

Example 13-16

Substantially the same polymerization procedures as in Examples 7 and 8 were repeated to produce the ethylene copolymers used as Component II, except that the flow ratio of hexane, ethylene, 1-butene, hydrogen were adjusted along with the polymerization temperature. The ethylene copolymers produced in Examples 7 and 8 were used as Component I. The polymer properties for Component I and Component II and the blend formulation are summarized in Table 5. The blends were prepared with using the twin-screw extruder (PCM-45, manufactured by IKEGAI, Co., Ltd., Japan). The screw rotates at 100-200 rpm. The screw barrel temperature was 220°C.

The powders were first dry blended with 2000 ppm Irganox® 1076 available from Ciba Geigy, 600 ppm Calcium Stearate, and 1000 ppm P-EPQ® available from Sando. The results of the testing of the various blend compositions are shown in Table 6.

5    Comparative Example 8-10

Substantially the same polymerization procedures as in Comparative Examples 7 was used to produce the ethylene homopolymers used for Component II. Also, the ethylene copolymer produced in Comparative Examples 7 was used as Component I. The polymer properties for Component I 10 and Component II and the blend formulation are summarized in Table 5. The blends were prepared using the same procedure as in Examples 13-16. The results of the testing of the various blend compositions are shown in Table 6.

Examples 9-16 show the excellent balance of properties such as impact strength at low temperature (as measured by  $G_c$  at 0 and -20°C and by Charpy 15 Impact Strength -20°C), processability (as measured by V at 100 l/s and by  $I_{21.6}$ ), and ESCR (as measured by PENT and by Bending ESCR TEST) for the various blend compositions and that such balance is best achieved by having the comonomer preferentially in the high molecular weight component.

Further, it is clear that the Example 13-16 exhibit superior properties compared 20 to those of Comparative Examples 8-10.

Table 1

	Units	Example 1	Example 2	Example 3	Example 4	Example 5	Example 6
<b>Polymerization Temperature</b>	(°C)	70	55	70	30	60	40
<b>Catalyst Activator</b>		Borate	MAO	MAO	MAO	MAO	MAO
<b>Isopentane Flow</b>	(g/hr)	2500	2500	2500	2500	1800	3600
<b>Ethylene Flow</b>	(g/hr)	700	850	650	850	600	600
<b>Comonomer Flow</b>	(g/hr)	20	110	30	200	30	176
<b>Hydrogen Flow</b>	(g/hr)	0.3	0.3	0.65	1	0.3	0.8
<b>Density</b>	(g/cm <sup>3</sup> )	0.929	0.910	0.935	0.887	0.934	0.890
<b>MFR</b>	(g/10 min)	0.5	0.02	0.36	0.07	0.07	0.23
<b>M<sub>w</sub>/M<sub>n</sub></b>		4.5	4.2	4.1	4.8	3.5	3.8
<b>Gradient<sup>a1</sup></b>		0.0013	0.0044	0.0011	0.0098	0.0011	0.0086
<b>CFC 1<sup>a2</sup></b>		-0.053	-0.026	-0.061	-0.015	-0.061	-0.017
<b>CFC 2<sup>a3</sup></b>	(wt%)	3.1	1.7	3.8	1.1	3.8	1.3

<sup>a1</sup> Gradient means a gradient of an approximate straight line obtained from a comonomer content distribution profile.

<sup>a2</sup> CFC 1 means, in CFC, a gradient of an approximate straight line obtained from the relationship between an arbitrary temperature (falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is 10°C higher than the first temperature) and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature at which point the molecular weight distribution profile exhibits a peak having a maximum intensity.

<sup>a3</sup> CFC 2 means a per cent of the sum of respective amounts of copolymer fractions extracted at temperatures which are at least 10°C lower than the above mentioned first temperature to the total amount of copolymer fractions as measured by CFC.

Table 1 (Continued)

	Units	Example 7	Example 8
<b>Polymerization Temperature</b>	(°C)	80	80
<b>Catalyst Activator</b>		Borate	Borate
<b>Hexane Flow</b>	(kg/hr)	46.2	46.2
<b>Ethylene Flow</b>	(kg/hr)	5.0	5.0
<b>Comonomer Flow</b>	(kg/hr)	0.11	0.05
<b>Hydrogen Flow</b>	(g/hr)	0.15	0.15
<b>Density</b>	(g/cm <sup>3</sup> )	0.9295	0.9378
<b>MFR</b>	(g/10 min)	0.012	0.013
<b>M<sub>w</sub>/M<sub>n</sub></b>		5.50	5.81
<b>Gradient<sup>*1</sup></b>		0.0010	0.0007
<b>CFC 1<sup>*2</sup></b>		-0.008	-0.205
<b>CFC 2<sup>*3</sup></b>	(wt%)	0.0	0.0

5

\*1 Gradient means a gradient of an approximate straight line obtained from a comonomer content distribution profile.

10

\*2 CFC 1 means, in CFC, a gradient of an approximate straight line obtained from the relationship between an arbitrary temperature (falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is 10°C higher than the first temperature) and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature at which point the molecular weight distribution profile exhibits a peak having a maximum intensity.

15

\*3 CFC 2 means a per cent of the sum of respective amounts of copolymer fractions extracted at temperatures which are at least 10°C lower than the above mentioned first temperature to the total amount of copolymer fractions as measured by CFC.

Table 2

	Example 1	Comparative Example 1	Comparative Example 2	Comparative Example 3	Comparative Example 4	Comparative Example 5	Comparative Example 6	Comparative Example 7
Density g/cm <sup>3</sup>	0.929	0.883	0.926	0.912	0.910	0.912	0.905	0.930
MFR g/10min	0.510	0.315	2.1	4.5	2.9	3.9	1.3	0.015
M <sub>w</sub> /M <sub>n</sub>	4.5	3.5	2.6	2.5	2.1	4.5	2.4	7.8
Gradient <sup>a1</sup>	0.0013	0.0030	-0.00005	-0.00003	-0.0007	0.0037	-0.0013	0.0041
CFC 1 <sup>a2</sup>	-0.053	-0.010	-0.016	-0.033	0.000	-0.016	0.000	0.005
CFC 2 <sup>a3</sup>	3.1	18.5	10.8	13.4	9.3	12.3	14.5	8.0

<sup>a1</sup> Gradient means a gradient of an approximate straight line obtained from a comonomer content distribution profile.

<sup>a2</sup> CFC 1 means, in CFC, a gradient of an approximate straight line obtained from the relationship between an arbitrary temperature (falling within the range of between a first temperature at which a maximum amount of extraction is exhibited and a second temperature which is 10°C higher than the first temperature) and a point on a molecular weight distribution profile of a copolymer fraction extracted at the arbitrary temperature at which point the molecular weight distribution profile exhibits a peak having a maximum intensity.

5

<sup>a3</sup> CFC 2 means a per cent of the sum of respective amounts of copolymer fractions extracted at temperatures which are at least 10°C lower than the above mentioned first temperature to the total amount of copolymer fractions as measured by CFC.

10

15

**Table 3**

Example #	Low Mw Component (Component II)				High Mw Component (Component I)			
	$I_2$ g/10min	mole % butene	density g/cm <sup>3</sup>	wt % in blend	$I_2$ g/10min	mole % butene	density g/cm <sup>3</sup>	wt % in blend
9	25.96	1.42	0.9380	48	0.00872	5.96	0.9033	52
10	34.9	2.56	0.9378	48	0.01085	2.91	0.9148	52
11	31.6	4.99	0.9219	48	0.00194	1.45	0.9203	52
12	19.1	6.21	0.9210	48	0.01085	0	0.9484	52

Table 4

	Example 9	Example 10	Example 11	Example 12
<b>Melt Flow Properties</b>				
$I_2$	g/10 min	0.08	0.10	0.03
$I_3$	g/10 min	0.25	0.32	0.11
$I_{1w}$	g/10 min	0.89	1.04	0.45
$I_{11,6}$	g/10 min	4.89	5.5	2.47
$I_{1w}/I_2$		11.1	10.4	15
$I_{2,10}/I_3$		19.6	17.2	22.5
$I_{2,10}/I_2$		61.1	55	82.3
<b>Density</b>	g/cm <sup>3</sup>	0.9241	0.9273	0.9251
<b>Batene Content</b>	Mole %	4	3.18	3.18
<b>GPC Analysis</b>				
<b>Mn</b>	g/mole	33700	32500	35500
<b>Mw</b>	g/mole	203000	201000	279000
<b>Mw/Mn</b>	-	6.02	6.18	7.86
<b>Rheology</b>				
Viscosity at 0.1 l/s	Pa.s	69102	50522	124986
Viscosity at 100 l/s	Pa.s	2656	2510	3273
<b>Mechanical Properties</b>				
<b>Tensile Properties</b>				
Yield Stress	Mpa	10.83	12.47	11.71
Ultim. Stress	Mpa	30.86	31.65	31.63
Elongation	%	617	704	764
Toughness	Mpa	102	124	133
Slope SII	Mpa	4.66	4.64	3.92
2% Sec. Mod.	Mpa	216	309	244
Young's Modulus	Mpa	308	354	282
<b>Impact Properties</b>				
Gc + 0C	kJ/m <sup>2</sup>	76.4	18.6	35.1
Gc -20C	kJ/m <sup>2</sup>	14.9	4.2	4.3
<b>PENT</b>	Min.	>10 <sup>3</sup>	>10 <sup>3</sup>	>10 <sup>3</sup>
2.4 Mpa		226	212	245
<b>Intrinsic Tear</b>	g/mil.	85.8	70.9	56.6
<b>Haze (0.5 mm)</b>	%			97.1

Table 5

Example #	Low Mw Component (Component II)				High Mw Component (Component I)			
	I <sub>2</sub> g/10min	mole % 1-butene	density g/cm <sup>3</sup>	wt % in blend	I <sub>2</sub> g/10min	mole % 1-butene	density g/cm <sup>3</sup>	wt % in blend
Example 13	67.3	0.01	0.9729	50	0.012	0.76	0.9295	50
Example 14	380	0.01	0.9783	50	0.012	0.76	0.9295	50
Example 15	380	0.01	0.9783	50	0.013	0.16	0.9378	50
Example 16	380	0.01	0.9783	60	0.013	0.16	0.9378	40
Comp.Ex.8	1113	0	0.9753	50	0.015	0.95	0.9306	50
Comp.Ex.9	280	0	0.9795	50	0.015	0.95	0.9306	50
Comp.Ex.10	280	0	0.9795	60	0.015	0.95	0.9306	40

Table 6

	Example 13	Example 14	Example 15	Example 16	Comparative Ex. 8	Comparative Ex. 9	Comparative Ex. 10
<b>Melt Flow Properties</b>							
$I_2$	g/10 min	0.12	0.12	0.13	0.30	0.13	0.18
$I_3$	g/10 min	0.51	0.49	0.45	1.29	0.54	0.74
$I_{2,6}$	g/10 min	10.9	10.8	11.6	37.0	13.9	20.1
$I_{2,6}/I_2$		90.8	89.8	92.0	125.5	109.5	111.4
<b>Density</b>	g/cm <sup>3</sup>	0.9550	0.9558	0.9611	0.9647	0.9551	0.9560
<b>Impact Properties</b>							
Charpy +23C	kg/cm/cm <sup>2</sup>	23.1	18.9	29.5	11.0	17.6	13.5
Charpy -20C	kg/cm/cm <sup>2</sup>	17.0	11.4	19.1	7.4	12.5	5.2
<b>ESCR</b>							
Bending 80C	hr.	1100	>2,000	50	11	170	400
50C	hr.	>2,000	>2,000	330	140	1,000	>2,000
							360

## What is claimed is:

1. 1. An ethylene copolymer comprising a copolymer of ethylene with at least one  
2 comonomer selected from the group consisting of a compound represented  
3 by the formula  $H_2C = CHR$  wherein R is a  $C_1-C_{20}$  linear, branched or cyclic  
4 alkyl group or a  $C_6-C_{20}$  aryl group, and a  $C_4-C_{20}$  linear, branched or cyclic  
5 diene, prepared by a process, which process comprises copolymerizing said  
6 ethylene with said comonomer by slurry polymerization in the presence of a  
7 solid catalyst system comprising: a support, a transition metal compound,  
8 and an activator capable of converting the transition metal compound into a  
9 catalytically active transition metal complex;  
10 wherein said ethylene copolymer has the following properties (1) to (4):
  - 11 (1) a density d (g/cm<sup>3</sup>) of from 0.870 to 0.980;
  - 12 (2) an  $M_w/M_n$  of from 2.5 to 10, wherein  $M_w$  and  $M_n$  are, respectively, a  
13 weight average molecular weight and a number average molecular  
14 weight, both as measured by gel permeation chromatography (GPC);
  - 15 (3) when, in cross fractionation chromatography (CFC) of said ethylene  
16 copolymer, with respect to extraction at an arbitrary temperature  
17  $T(^{\circ}C)$  falling within the range of between a first temperature at  
18 which a maximum amount of extraction is exhibited and a second  
19 temperature which is the lower temperature of either the temperature  
20 of 10°C higher than said first temperature or 96°C, the relationship  
21 between said arbitrary temperature  $T(^{\circ}C)$  and a point in molecular  
22 weight on a molecular weight distribution profile of a copolymer  
23 fraction extracted at said arbitrary temperature  $T(^{\circ}C)$  at which point  
24 in molecular weight said molecular weight distribution profile of the  
25 copolymer fraction shows a peak having a maximum intensity is

26 treated by the least squares method to obtain an approximate straight  
27 line within the range of between said first temperature and said  
28 second temperature; if there is the copolymer fraction the amount of  
29 which is less than 1% by weight on the total amount, excluding  
30 purge, of copolymer fractions extracted at temperatures in the  
31 overall range of extraction temperatures in CFC, the copolymer  
32 fraction can be excluded from the calculation for the approximate  
33 straight line; the approximate straight line has a gradient within the  
34 range defined by the formula (I):

35

$$-1 \leq \{\log M_p(T^1) - \log M_p(T^2)\} / (T^1 - T^2) \leq -0.005 \quad (I)$$

37

39            $T^1$  and  $T^2$  are two different arbitrary extraction temperatures  $T(^{\circ}C)$   
40           within the range of between said first temperature and said second  
41           temperature, and

42  $M_p(T^1)$  and  $M_p(T^2)$  are, respectively, molecular weights  
43 corresponding to  $T^1$  and  $T^2$  on said approximate straight line; and

44 (4) the measurement of said ethylene copolymer by CFC shows  
45 characteristics such that the sum of respective amounts of copolymer  
46 fractions extracted at temperatures which are at least 10°C lower  
47 than said first temperature as defined above is 8% by weight or less,  
48 based on the total amount, excluding purge, of copolymer fractions  
49 extracted at temperatures in the overall range of extraction  
50 temperatures in CFC.

1 2. The ethylene copolymer according to claim 1; wherein the Mw/Mn ratio

2 satisfies the following inequality;

3  $1.25\log M_w - 2.5 \leq M_w/M_n \leq 3.50\log M_w - 11.0$ .

1 3. The ethylene copolymer according to claim 1, wherein, said ethylene  
2 copolymer has the following property (5) with the properties (1), (2), (3)  
3 and (4);

(5) within a range in molecular weight of said ethylene copolymer  
which is defined by the formula (II):

$$7 \quad \log(M_t) - \log(M_c) \leq 0.5 \quad (II)$$

10 Mt is a point in molecular weight on a molecular weight distribution  
11 profile at which said profile shows a peak having a maximum  
12 intensity, and

13                   Mc is an arbitrary point in molecular weight on said molecular  
14                   weight distribution profile,

15 and wherein said molecular weight distribution profile is obtained  
16 together with a comonomer content distribution profile by subjecting  
17 said ethylene copolymer to gel permeation chromatography/Fourier  
18 transformation infrared spectroscopy (GPC/FT-IR), then  
19 an approximate straight line obtained from said comonomer content  
20 distribution profile by the least squares method has a gradient within  
21 the range defined by the formula (III):

$$23 \quad 0.0005 \leq \{C(Mc^1) - C(Mc^2)\} / (\log Mc^1 - \log Mc^2) \leq 0.05 \quad (III)$$

25       wherein:

26        $Mc^1$  and  $Mc^2$  are two different arbitrary points ( $Mc$ ) in molecular weight  
27       which satisfy the formula (II), and  
28        $C(Mc^1)$  and  $C(Mc^2)$  are, respectively, comonomer contents corresponding  
29       to  $Mc^1$  and  $Mc^2$  on said approximate straight line

1       4. The ethylene copolymer according to any of claims 1 to 3, wherein the  
2        $M_w/M_n$  ratio is of from 3 to 7.

1       5. The ethylene copolymer according to any of claims 1 to 4, wherein, with  
2       respect to property (3), said approximate straight line obtained from said  
3       molecular weight distribution profile obtained by CFC of said polymer  
4       fraction has a gradient with the range defined by the following formula (IV):

5

6        $-0.1 \leq \{\log Mp(T^1) - \log Mp(T^2)\} / (T^1 - T^2) \leq -0.01$        (IV)

7

8       wherein  $T^1$ ,  $T^2$ ,  $Mp(T^1)$  and  $Mp(T^2)$  are as defined for formula (I) above.

1       6. The ethylene copolymer according to any of claims 3 to 5, wherein, with  
2       respect to property (5), said approximate straight line obtained from said  
3       comonomer content distribution profile obtained by GPC/FT-IR of said  
4       ethylene comonomer has a gradient within the range defined by the  
5       following formula (V):

6

7        $0.001 \leq \{C(Mc^1) - C(Mc^2)\} / (\log Mc^1 - \log Mc^2) \leq 0.02$        (V)

8

9       wherein  $Mc^1$ ,  $Mc^2$ ,  $C(Mc^1)$  and  $C(Mc^2)$  are as defined for formula (III)  
10      above..

1    7. The ethylene copolymer according to any of claims 1 to 6, wherein, with  
2    respect to property (4), said sum of respective amounts of copolymer  
3    fractions extracted at temperatures which are at least 10°C lower than said  
4    first temperature is 5 % by weight or less, based on the total amount,  
5    excluding purge, of copolymer fractions extracted at temperatures in the  
6    overall range of extraction temperatures in CFC.

1    8. A process for preparing the ethylene copolymer of any of claims 1 to 7,  
2    which process comprises copolymerizing said ethylene with said  
3    comonomer by slurry polymerization in the presence of a solid catalyst  
4    system comprising: a support, a transition metal compound, and an activator  
5    capable of converting the transition metal compound into a catalytically  
6    active transition metal complex.

1    9. The process according to claim 8 wherein said solid catalyst system  
2    comprises:  
3    a supported catalyst component comprising:  
4    (a) a support material, an organometal compound wherein the metal is  
5    selected from Groups 2-13 of the Periodic Table of the Elements,  
6    germanium, tin, and lead; and  
7    (b) an activator compound comprising (b-1) a cation which is capable of  
8    reacting with a transition metal compound to form a catalytically  
9    active transition metal complex, and  
10   (c) a compatible anion (b-2) having up to 100 nonhydrogen atoms and

11 containing at least one substituent comprising an active hydrogen  
12 moiety; and  
13 (d) a transition metal compound.

1 10. The process according to claim 8, wherein the cation (b-1) is selected from  
2 the group consisting of Brønsted acidic cations, carbonium cations,  
3 silylium cations, and cationic oxidizing agents, and in the anion (b-2) the  
4 substituent comprising an active hydrogen moiety corresponds to the  
5 following formula (VI):

6

7  $G_q(T-H)_r$  (VI)

8

9 wherein;

10 G is a polyvalent hydrocarbon radical,  
11 T is O, S, NR, or PR, wherein R is a hydrocarbyl radical, a  
12 trihydrocarbysilyl radical, a trihydrocarbyl germyl radical or hydrogen,  
13 q is 0 or 1, and  
14 r is an integer from 1 to 3.

1 11. The process according to claim 9 wherein the compatible anion portion of  
2 the activator compound corresponds to the following formula (VII):

3

4  $[M'^{m+} Q_n(G_q(T-H)_r)_z]^{q-}$  (VII)

5

6 wherein;

7 M' is a metal or metalloid selected from Groups 5-15 of the Periodic  
8 Table of the Elements;

9       Q independently in each occurrence is selected from the group consisting  
10      of hydride, dihydrocarbylamido, halide, hydrocarbyloxide, hydrocarbyl,  
11      and substituted-hydrocarbyl radicals, including halo-substituted  
12      hydrocarbyl radicals, and hydrocarbyl- and halohydrocarbyl-substituted  
13      organo-metalloid radicals. the hydrocarbyl portion having from 1 to 20  
14      carbons with the proviso that in not more than one occurrence is Q halide;  
15      G is a polyvalent hydrocarbon radical having r+1 valencies bonded to M'  
16      and T; wherein  
17      T is O, S, NR, or PR, wherein R is a hydrocarbyl radical, a  
18      trihydrocarbysilyl radical, a trihydrocarbyl germyl radical or hydrogen;  
19      m is an integer from 1 to 7;  
20      n is an integer from 0 to 7;  
21      q is an integer of 0 or 1;  
22      r is an integer from 1 to 3;  
23      z is an integer from 1 to 8;  
24      d is an integer from 1 to 7; and  
25      n+z-m = d.

1       12. The process according to any of claims 8 to 10 wherein the solid catalyst  
2      system is obtained by combining:  
3        (1) a supported catalyst component obtained by  
4           (A) subjecting the support material to a thermal treatment at 100 °C  
5            to 1000 °C; combining the thermally treated support material  
6            with the organometal compound in a suitable diluent or solvent;  
7            and subsequently combining the resulting product with the  
8            activator compound; or  
9        (B) combining the activator compound with the organometal

10 compound to form an adduct; and combining the adduct with the  
11 support material; or

12 (C) combining a water containing support material with the  
13 organometal compound; and combining the resulting product  
14 with

15 (D) the activator compound; and  
16 (E) a transition metal compound.

1 13. The process according to claim 8, wherein the solid catalyst system  
2 comprises a supported catalyst component which results from admixing;  
3 (a) a support material and an alumoxane which component contains 15 to  
4 40 weight percent of aluminum, based on the total weight of the support  
5 material and alumoxane, which is obtained by;

6 (i) heating said support material and alumoxane under an inert  
7 atmosphere for a period and at a temperature sufficient to fix  
8 alumoxane to the support material, to provide a supported  
9 catalyst component wherein not more than 10 percent aluminum  
10 present in the supported catalyst component is extractable in a  
11 one-hour extraction with toluene at 90°c using 10 ml toluene per  
12 gram of supported catalyst component; and

13 (ii) optionally, subjecting the product produced in step (a) to one or  
14 more wash steps to remove alumoxane not fixed to the support  
15 material; and

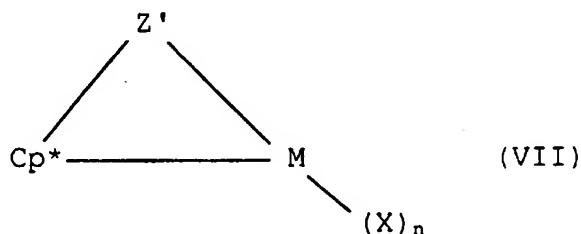
16 (b) a transition metal compound.

1 14. The process according to any of claims 8 to 13, wherein the transition  
2 metal compound contains at least one cyclic or noncyclic  $\pi$ -bonded

3 anionic ligand group.

1 15. The process according to claim 14, wherein said transition metal compound  
2 is a bridged monocyclopentadienyl or mono (substituted  
3 cyclopentadienyl) transition metal compounds represented by: the  
4 following formula (VII):

5



6

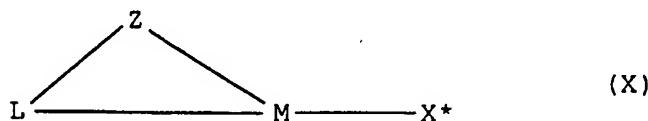
7 wherein:

8 M is a metal of groups 3-5, especially a group 4 metal, particularly  
9 titanium;

10 Cp\* is a substituted cyclopentadienyl group bound to Z' and, in an  $\eta^5$   
11 bonding mode, to M or such a group is further substituted with from one to  
12 four substituents selected from the group consisting of hydrocarbyl, silyl,  
13 germyl, halo, hydrocarbyloxy, amine, and mixture thereof, said substituent  
14 having up to 20 nonhydrogen atoms, or optionally, two such further  
15 substituents together cause Cp\* to have a fused ring structure;

16 Z' is a divalent moiety other than a cyclic or noncyclic  $\pi$ -bonded anionic  
17 ligand, said Z' comprising boron, or a member of Group 14 of the Periodic  
18 Table of the Elements, and optionally nitrogen, phosphorus, sulfur or  
19 oxygen, said moiety having up to 20 non-hydrogen atoms, and optionally  
20 Cp\* and Z' together form a fused ring system;

21        X independently in each occurrence represents an anionic ligand group  
 22        (other than a cyclic, aromatic  $\pi$ -bonded anionic ligand group) selected  
 23        from the group of hydrocarbyl, hydrocarbylene (including  
 24        hydrocarbadienyl), hydrocarbyloxy, hydride, halo, silyl, germyl, amide,  
 25        and siloxy radicals having up to 50 nonhydrogen atoms; and  
 26        n is 1 or 2 depending on the valence of M; or by the following formula  
 27        (X):  
 28



30        wherein:  
 31        M is titanium or zirconium in the +2 formal oxidation state;  
 32        L is a group containing a cyclic, delocalized, anionic,  $\pi$ -system through  
 33        which the group is bonded to M, and which group is also bonded to Z;  
 34        Z is a moiety bonded to M via a  $\sigma$ -bond, comprising boron, or a member  
 35        of Group 14 of the Periodic Table of the Elements, and also comprising  
 36        nitrogen, phosphorus, sulfur or oxygen, said moiety having up to 60 non-  
 37        hydrogen atoms; and  
 38        X\* is a neutral, conjugated or nonconjugated diene, optionally substituted  
 39        with one or more hydrocarbyl groups, said X having up to 40 carbon atoms  
 40        and forming a  $\pi$ -complex with M.

1        16 The process according to any of claims 8 to 15, wherein the support  
 2        material is selected from the group consisting of silica, alumina, mixed  
 3        oxides of silica and one or more Group 2 or 13 metal oxides, alumina,  
 4        magnesia, and titania.

- 1 17. A polymer blend composition comprising;
- 2 (I) from 1 to 99 % by weight based on the combined weight of
- 3 Components (I) and (II) of the ethylene copolymer of any of claims 1
- 4 to 7; and
- 5 (II) from 1 to 99 % by weight based on the combined weight of
- 6 Components (I) and (II) of either
- 7 (1) an ethylene homopolymer which has been prepared with a catalyst
- 8 component other than that used in the process of any of claims 8
- 9 to 16, or
- 10 (2) an ethylene/α-olefin copolymer which is different from that of
- 11 component (I).

- 1 18. The polymer blend composition of claim 17, wherein
- 2 (I) Component (I) is said ethylene copolymer of any of claims 1 to 7
- 3 prepared by the process of any of claims 8 to 16; and
- 4 (II) Component (II) comprises;
- 5 (1) an ethylene homopolymer prepared by a catalyst component other
- 6 than said catalyst component of any of claims 8 to 16; or
- 7 (2) a homogeneous narrow composition distribution ethylene/α-olefin
- 8 interpolymer; or
- 9 (3) a heterogeneous broad composition distribution ethylene/α-olefin
- 10 interpolymer; or
- 11 (4) the ethylene/α-olefin copolymer (I) having a different  $I_2$ , or density,
- 12 or  $M_w$ , or  $M_w/M_n$ ; or
- 13 (5) a combination of any two or more of (II)(1), (II)(2), or (II)(3) or
- 14 (II)(4).

1 19. The polymer blend composition of claim 18 having;

2 1) a density of from 0.870 to 0.980 g/cm<sup>3</sup>,

3 2) a melt index, (I<sub>2</sub>), of from 0.0001 to 10000 g/10 min,

4 3) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 100, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from 20 to 200,  
5 and

6 4) an M<sub>w</sub>/M<sub>n</sub> of from 5 to 50; and wherein

7 (a) Component (I) is said ethylene copolymer of any of claims 1 to  
8 7; and is present in an amount of from 10 to 90 % by weight  
9 based on the combined weight of Component (I) and  
10 Component (II); and

11 i) has a density of from 0.870 to 0.980 g/cm<sup>3</sup>,

12 ii) a melt index (I<sub>2</sub>) of from 0.0001 to 10000 g/10 min,

13 iii) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 30, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from  
14 15 to 65,

15 iv) an M<sub>w</sub>/M<sub>n</sub> of from 2.5 to 10; and

16 (b) Component (II) is present in an amount of from 10 to 90 % by  
17 weight based on the combined weight of Component (I) and  
18 Component (II); and has;

19 i) a density of from 0.915 to 0.985 g/cm<sup>3</sup>,

20 ii) a melt index (I<sub>2</sub>) of from 0.0001 to 10000 g/10 min; and

21 (c) Component (II)(1) when present has

22 i) an I<sub>10</sub>/I<sub>2</sub> of from 5 to 40, or an I<sub>21.6</sub>/I<sub>2</sub> of from 15 to 80, and

23 ii) an M<sub>w</sub>/M<sub>n</sub> of from 2.5 to 12; and

24 (d) Component (II) (2) when present has an I<sub>10</sub>/I<sub>2</sub> of  
25 from 5 to 25, or an I<sub>21.6</sub>/I<sub>2</sub> of from 10 to 50; and

26 (e) Component (II)(3) when present has;

27 i) an I<sub>10</sub>/I<sub>2</sub> of from 5 to 40 or an I<sub>21.6</sub>/I<sub>2</sub> of from 15 to 80, and

1 20. The polymer blend composition of claim 18 having

2 1) a density of from 0.915 to 0.975 g/cm<sup>3</sup>,

3 2) a melt index, (I<sub>2</sub>), of from 0.001 to 5000 g/10 min,

4 3) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 90, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from 30 to 180,

5 and

6 4) an M<sub>w</sub>/M<sub>n</sub> of from 3 to 45; and wherein

7 (a) Component (I) is said ethylene copolymer of any of claims 1 to

8 7; and is present in an amount from 25 to 75 % by weight

9 based on the combined weight of Components (I) and

10 Component (II); and has;

11 i) a density of from 0.890 to 0.965 g/cm<sup>3</sup>,

12 ii) a melt index, (I<sub>2</sub>), of from 0.001 to 5000 g/10 min,

13 iii) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 28, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from

14 18 to 55,

15 iv) an M<sub>w</sub>/M<sub>n</sub> of from 2.8 to 8; and

16 (b) Component (II) is present in an amount from 25 to 75 % by

17 weight based on the combined weight of Components (I) and

18 Component (II); and has a density of from 0.935 to 0.983

19 g/cm<sup>3</sup>, and a melt index (I<sub>2</sub>) of from 0.001 to 5000 g/10 min;

20 and

21 (c) Component (II)(1) when present has an

22 i) an I<sub>21.6</sub>/I<sub>2</sub> of from 18 to 70 or an I<sub>10</sub>/I<sub>2</sub> of from 5.3 to 35,

1 21. The polymer blend composition of claim 18 having;

2 1) a density of from 0.935 to 0.970 g/cm<sup>3</sup>,

3 2) a melt index, (I<sub>2</sub>), of from 0.01 to 3000 g/10 min,

4 3) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 80, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from 40 to 150,

5 and

6 4) an M<sub>w</sub>/M<sub>n</sub> of from 5 to 40; and wherein

7 (a) Component (I) is said ethylene copolymer of any of claims 1 to

8 3; and is present in an amount from 35 to 65 % by weight

9 based on the combined weight of Component (I) and

10 Component (II); and has;

11 i) a density of from 0.915 to 0.955 g/cm<sup>3</sup>,

12 ii) a melt index (I<sub>2</sub>) of from 0.01 to 3000 g/10 min,

13 iii) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5.5 to 25, or an I<sub>21.6</sub>/I<sub>2</sub> ratio of from

14 20 to 50, and

15 iv) an M<sub>w</sub>/M<sub>n</sub> of from 3 to 7; and

16 (b) Component (II) is present in an amount from 35 to 65 % by  
17 weight based on the combined weight of Component (I) and  
18 Component (II), and has a density of from 0.955 to 0.980  
19 g/cm<sup>3</sup>, and a melt index (I<sub>2</sub>) of from 0.01 to 3000 g/10 min;  
20 and

21 (c) Component (II)(1) when present has;  
22 i) an I<sub>21.6</sub>/I<sub>2</sub> of from 20 to 60, or an I<sub>10</sub>/I<sub>2</sub> of from 5.5 to 30;  
23 and  
24 ii) an M<sub>w</sub>/M<sub>n</sub> of from 3 to 9; and

25 (d) Component (II)(2) when present has;  
26 i) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5.5 to 20, or an I<sub>21.6</sub>/I<sub>2</sub> of from 15 to  
27 40, and  
28 ii) has an M<sub>w</sub>/M<sub>n</sub> less than 3; and

29 (e) Component (II)(3) when present has;  
30 i) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5.5 to 30, or an I<sub>21.6</sub>/I<sub>2</sub> of from 25 to  
31 60, and  
32 ii) an M<sub>w</sub>/M<sub>n</sub> of from 4 to 9; and

33 (f) Component (II)(4) when present has;  
34 i) an I<sub>10</sub>/I<sub>2</sub> ratio of from 5 to 30, or an I<sub>21.6</sub>/I<sub>2</sub> of from 20 to  
35 50, and  
36 ii) an M<sub>w</sub>/M<sub>n</sub> of from 3 to 7.

1 22. The polymer blend composition of Claim 18, wherein Component (II)(2)  
2 contains long chain branches.

1 23. The polymer blend composition of Claim 18, wherein Component (II)(2)  
2 contains long chain branches in the range of 0.01 to 3 per 1000 carbon

3 atoms.

1 24. The polymer blend composition of Claim 18, wherein Component (I) has a  
2 lower density and a higher molecular weight than Component (II).

1 25. The polymer blend composition of Claim 18, wherein Component (II)(2)  
2 contains long chain branches in the range of 0.1 to 3 per 1000 carbon  
3 atoms.

1 26. A process for forming a polymer blend composition, which process  
2 comprises the steps of:

3 (A) preparing an ethylene/α-olefin copolymer (I) by the process of  
4 any of Claims 8 to 16;  
5 (B) contacting under polymerization conditions a feedstream  
6 comprising ethylene, optionally at least one α-olefin  
7 comonomer, and an ethylene polymerization catalyst, to form  
8 (II) an ethylene homopolymer which has been prepared with a  
9 catalyst component other than that used in the process of any  
10 of Claims 8 to 16, or an ethylene/α-olefin copolymer; and  
11 (C) combining the ethylene/α-olefin copolymer (I) with the  
12 ethylene homopolymer or ethylene/α-olefin interpolymer (II)  
13 to form (III) the polymer blend composition.

1 27. The process of Claim 26 wherein steps (A) and (B) are performed in  
2 different reactors.

1  
1 28. The process of Claim 26 wherein the reactors are operated in series and

2       step (A) is performed in the first reactor(s) and step (B) is performed in  
3       the second reactor(s)

1       29. The process of Claim 26 wherein the reactors are operated in series and  
2       step (B) is performed in the first reactor(s) and step (A) is performed in  
3       the second reactor(s).

1       30. The process of Claim 26 wherein;

2           (a) step (B) is performed under slurry phase polymerization  
3           conditions, or solution phase polymerization conditions, or gas  
4           phase polymerization conditions; and  
5           (b) the ethylene polymerization catalyst used in step (B) is a  
6           catalyst described in Claim 8 to 16, or a Ziegler catalyst, or an  
7           unsupported single site catalyst, or a supported single site  
8           catalyst other than that described in Claim 8 to 16, or a mixture  
9           of any two or more of said ethylene polymerization catalysts.

1       31. The process of Claim 26 wherein the ethylene polymerization catalyst of  
2       step (B) is a Ziegler ethylene polymerization catalyst comprising;  
3           (a) a solid support component is a magnesium halide or silica, and  
4           (b) a transition metal component represented by the formulas;

5  
6            $TrX'4-q(OR^1)_q$ ,  $TrX'4-qR^2_q$ ,  $VOX'3$  and  $VO(OR^1)_3$ ,  
7           wherein:  
8            $Tr$  is a Group IVB, VB, or VIB metal,  
9            $q$  is 0 or a number equal to or less than 4,

10                   X' is a halogen, and  
11                   R<sup>1</sup> is an alkyl group, aryl group or cycloalkyl group having  
12                   from 1 to 20 carbon atoms, and  
13                   R<sup>2</sup> is an alkyl group, aryl group, aralkyl group, or substituted  
14                   aralkyl group.

1   32. The process of Claim 26 wherein the reactors are operated in parallel.

1   33. The process of Claim 26, wherein Component I has a lower density and a  
2                   higher molecular weight than Component II.

1   34. The process of Claim 26 wherein the comonomer of step (B) is a C<sub>3</sub>-C<sub>20</sub>  $\alpha$ -  
2                   olefin.

1   35. The process of Claim 26 wherein the comonomer of steps (A) and (B) is  
2                   propylene, 1-butene, 1-pentene, 4-methyl-1-pentene, 1-octene, or 1-  
3                   hexene.

1   36. The process of Claim 26 wherein the comonomer of steps (A) and (B) is 1-  
2                   hexene or 1-octene.

1   37. The polymer blend composition prepared by the process of Claim 26.

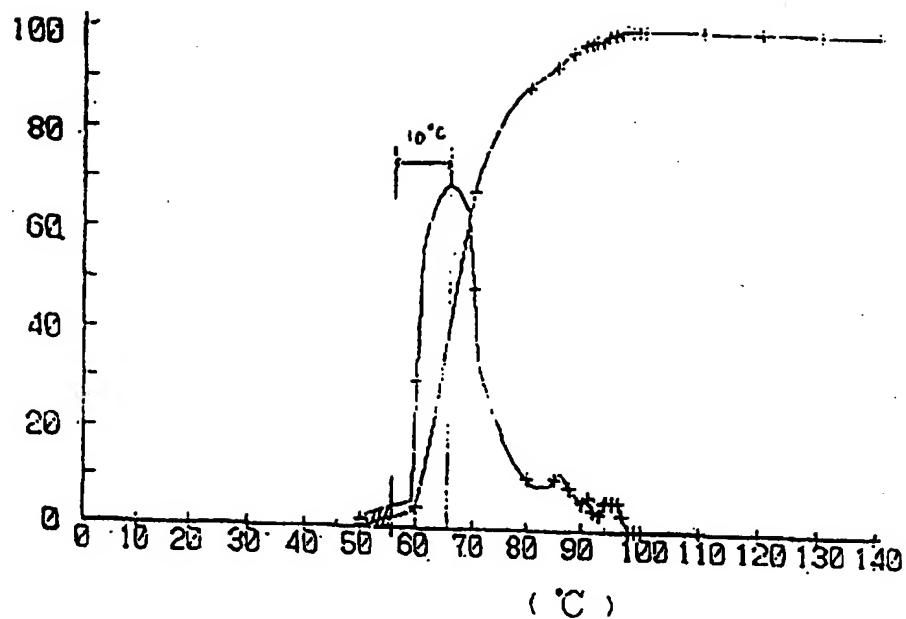
1   38. The sintering powder made from the ethylene copolymer of any of Claims  
2                   1 to 7.

1   39. A fabricated article made from the polymer blend composition of any of  
2                   Claims 17 to 25.

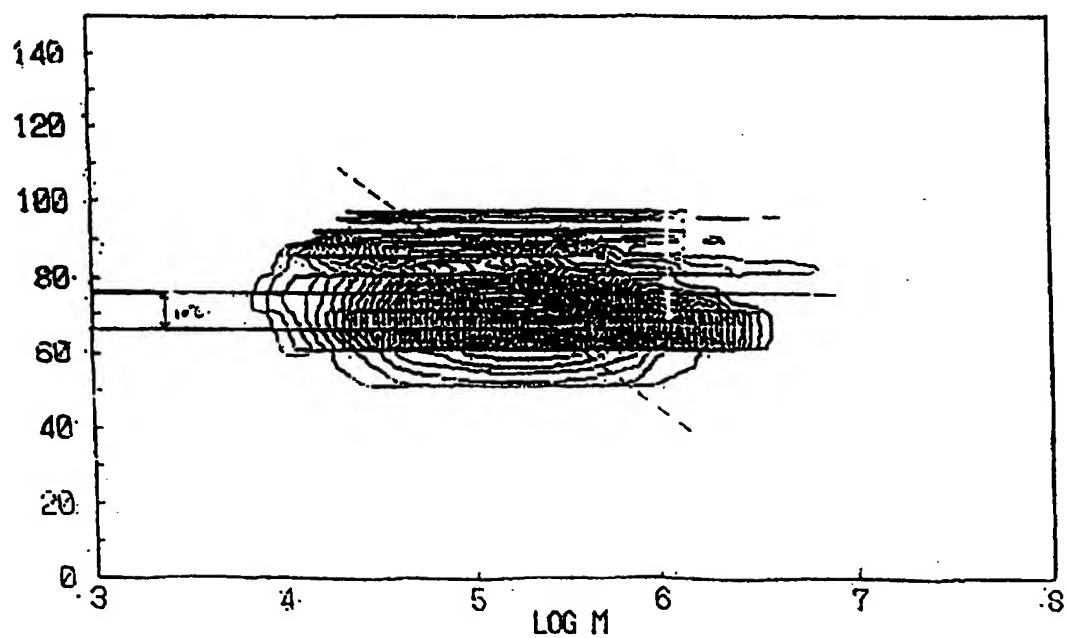
- 1    40. A fabricated article of claim 39 which is in the form of a film, fiber, or
- 2       sheet, or the result of a thermoforming, blow molding, injection molding
- 3       and rotational molding process.
  
- 1    41. A fabricated article of claim 39 comprising pipes, tubing, cable or wire
- 2       jackets, pipe coatings, geomembranes, thermoformed articles, stackable
- 3       plastic pallets, blow molded bottles or containers, or environmental pond
- 4       liners.

1/2

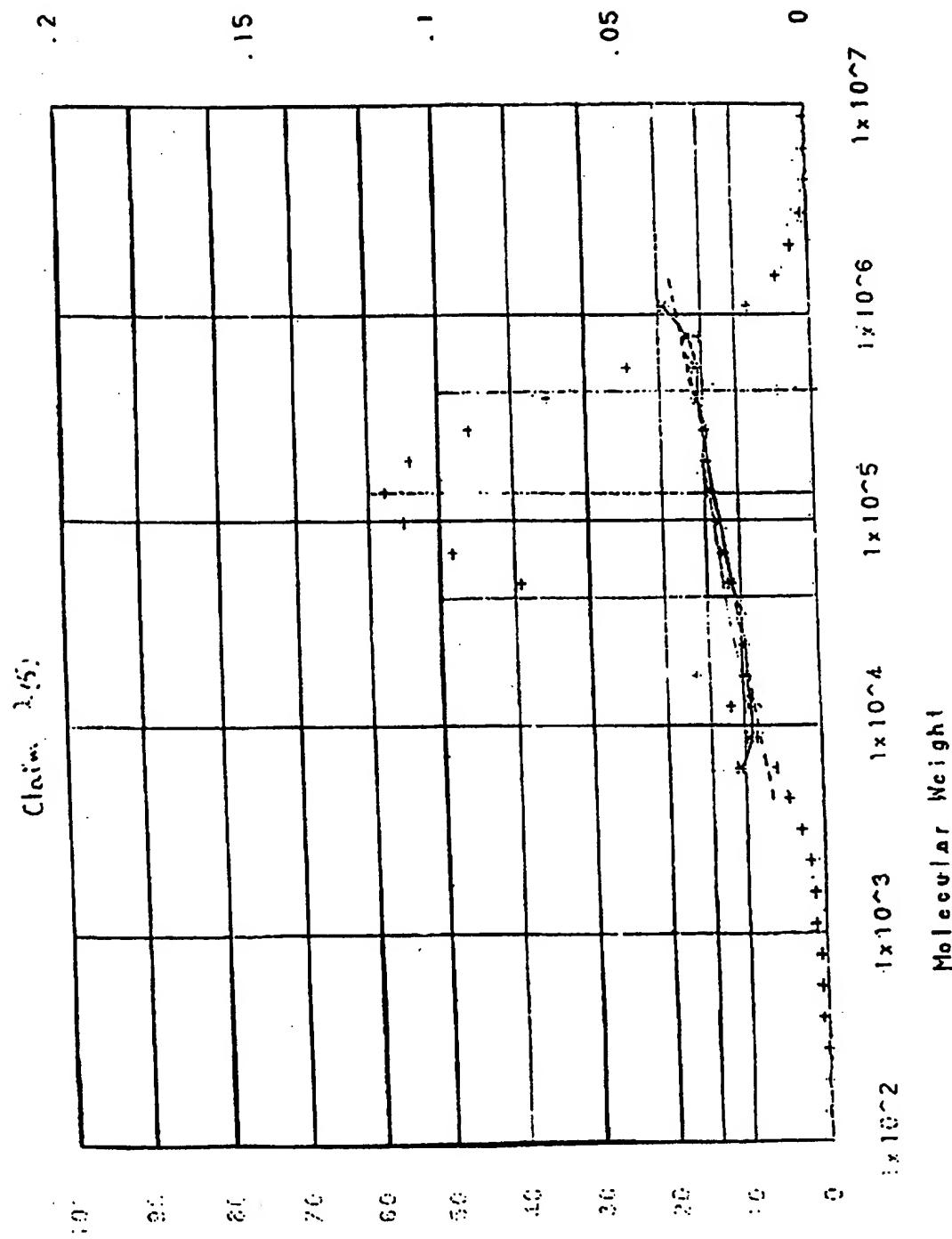
Claim 1 (2)



( °C )      Claim 1 (3)



Relative Intensity



# INTERNATIONAL SEARCH REPORT

Int'l Application No  
PCT/US 97/08466

**A. CLASSIFICATION OF SUBJECT MATTER**  
**IPC 6 C08F210/16 C08F297/08 C08F4/645 C08F2/14 C08L23/04**

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
**IPC 6 C08F**

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	WO 96 28480 A (DOW CHEMICAL CO) 19 September 1996 see claims ---	8-11
X	WO 93 11172 A (EXXON CHEMICAL PATENTS INC) 10 June 1993 see page 8, line 36 - page 9, line 11 see page 23, line 24 - page 24, line 8 see page 24, line 10 - page 26, line 26 see page 42, line 12 - page 43, line 34 see claims; examples ---	8-11
X	EP 0 117 492 A (BASF AG) 5 September 1984 see claims ---	8
X	EP 0 571 882 A (HOECHST AG) 1 December 1993 see claims; examples ---	8,12-16
		-/-

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

\* Special categories of cited documents :

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
- \*E\* earlier document but published on or after the international filing date
- \*L\* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- \*O\* document referring to an oral disclosure, use, exhibition or other means
- \*P\* document published prior to the international filing date but later than the priority date claimed

- \*T\* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
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Date of the actual completion of the international search

Date of mailing of the international search report

29 August 1997

16.10.97

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Authorized officer

Kaumann, E

## INTERNATIONAL SEARCH REPORT

Intern'l Application No  
PCT/US 97/08466

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 43 44 672 C (BASF AG) 14 June 1995 see claims; examples ---	8,12-16
X	WO 94 21691 A (MOBIL OIL CORP) 29 September 1994 see page 5, line 5 - page 15, line 27; claims; examples ---	8,12,13
X	WO 94 17112 A (DOW CHEMICAL CO) 4 August 1994 see page 9, line 15 - page 24, line 28; claims; examples ---	26-37
X	EP 0 447 035 A (MITSUI PETROCHEMICAL IND) 18 September 1991 see page 9, line 39 - line 41 see claims; examples see page 11, line 25 - line 27 ---	26-37
X	EP 0 572 003 A (IDEMITSU KOSAN CO) 1 December 1993 see claims; examples -----	26,28

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## INTERNATIONAL SEARCH REPORT

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PCT/US 97/08466

### Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1.  Claims Nos. because they relate to subject matter not required to be searched by this Authority, namely.
2.  Claims Nos. 1-7, 17-25, 38-41 because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:  
The subject matter and the scope of claim 1 is not clearly defined  
Claims 17 relates to claim 1  
Claims 38-41 relate to claim 1 or 17
3.  Claims Nos. because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

### Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1.  As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2.  As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3.  As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4.  No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

#### Remark on Protest

The additional search fees were accompanied by the applicant's protest.  
 No protest accompanied the payment of additional search fees.

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## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/US 97/08466

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